DRUM SANDER

MODEL G1066/G1066Z/G1079

INSTRUCTION MANUAL

Model G1066

Model G1066Z

COPYRIGHT © MAY, 2002 BY GRIZZLY INDUSTRIAL, INC.
WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.

THE INFORMATION IN THIS MANUAL REPRESENTS THE CONFIGURATION OF THE MACHINE AS IT IS CURRENTLY BEING SHIPPED. THE MACHINE CONFIGURATION CAN CHANGE AS PRODUCT IMPROVEMENTS ARE INCORPORATED. IF YOU OWN AN EARLIER VERSION OF THE MACHINE, THIS MANUAL MAY NOT EXACTLY DEPICT YOUR MACHINE . CONTACT CUSTOMER SERVICE IF YOU HAVE ANY QUESTIONS ABOUT DIFFERENCES. PREVIOUS VERSIONS ARE NOT AVAILABLE ONLINE.

PRINTED IN TAIWAN

WARNING

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement, and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

Table Of Contents

PAGE

1. **SAFETY**
   - SAFETY RULES FOR POWER TOOLS 2-3
   - SAFETY RULES FOR THE DRUM SANDER 4
2. **CIRCUIT REQUIREMENTS**
   - 220V OPERATION 5
   - FUSING 5
   - GROUNDING 5
   - EXTENSION CORDS 6
   - WIRING DIAGRAMS 6
3. **GENERAL INFORMATION**
   - COMMENTARY 7
   - UNPACKING 8
   - PIECE INVENTORY 8
   - HARDWARE RECOGNITION CHART 9
   - CLEAN UP 10
   - SITE CONSIDERATIONS 10
4. **ASSEMBLY**
   - BEGINNING ASSEMBLY 11
   - DUST PORTS 11
   - CRANK HANDLE 12
   - G1066Z CONTROL PANEL 12
5. **ADJUSTMENTS**
   - DRUM ALIGNMENT 13-15
   - PRESSURE ROLLERS 16
   - DUST SCOOP 17
   - V-BELT ALIGNMENT 17
   - PAPER REPLACEMENT G1066/G1079 18-19
   - PAPER REPLACEMENT G1066Z 19
   - DUST COLLECTION 20
   - CONVEYOR BELT 21
6. **OPERATIONS**
   - G1066Z CONTROL PANEL 22
   - TEST RUN 23
   - G1066/G1079 23
   - G1066Z 24-25
   - CHOOSING SANDPAPER 25
7. **MAINTENANCE**
   - GENERAL 26
   - LUBRICATION 26
   - BEARING REPLACEMENT 27
8. **CLOSURE** 28

G1066 DATA SHEET 29
G1066 PARTS BREAKDOWN 30-32
G1066 PARTS LIST 33
G1066 WIRING DIAGRAM 34
G1066Z DATA SHEET 35
G1066Z PARTS BREAKDOWN 36-38
G1066Z PARTS LIST 39-40
G1066Z WIRING DIAGRAM 41
G1079 DATA SHEET 42
G1079 PARTS BREAKDOWN 43-45
G1079 PARTS LIST 46
G1079 WIRING DIAGRAM 47
TROUBLESHOOTING 48
MAINTENANCE NOTES 49
WARRANTY AND RETURNS 50

SECTION 1: SAFETY

⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating This Equipment

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

⚠DANGER — **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING — **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION — **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.**

NOTICE — **This symbol is used to alert the user to useful information about proper operation of the equipment.**

⚠WARNING

Safety Instructions For Power Tools

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES**. Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
3. **KEEP WORK AREA CLEAN**. Cluttered areas and benches invite accidents.
4. **NEVER USE IN DANGEROUS ENVIRONMENT**. Do not use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
5. **KEEP CHILDREN AND VISITORS AWAY**. All children and visitors should be kept at a safe distance from work area.
6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **NEVER FORCE TOOL**. It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** Do not force tool or attachment to do a job for which it was not designed.

⚠WARNING

Safety Instructions For Power Tools

9. **USE PROPER EXTENSION CORD**. Make sure your extension cord is in good condition. Conductor size should be in accordance with the chart below. The amperage rating should be listed on the motor or tool nameplate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.

Minimum Gauge for Extension Cords

	LENGTH		
AMP RATING	25ft	50ft	100ft
0-6	18	16	16
7-10	18	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No

10. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.

11. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.

12. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.

13. **NEVER OVERREACH.** Keep proper footing and balance at all times.

14. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

15. **DISCONNECT TOOLS** before servicing and changing accessories, such as blades, bits, cutters, and the like.

16. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in off position before plugging in. Also, the magnetic switch on this machine may start if the switch gets bumped hard enough.

17. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.

18. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

19. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Do not leave tool until it comes to a complete stop.

20. **NEVER USE UNDER THE INFLUENCE** of alcohol or drugs, or when tired.

21. **NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to the operation of the machine are approved, correct, safe, and clearly understood.

⚠WARNING

Additional Safety Instructions For The Drum Sander

- **DO NOT** allow anyone to stand at the outfeed end when feeding your stock.
- **DO NOT** jam workpiece into the machine during operation. Firmly grasp the workpiece in both hands and ease it into the machine using light pressure.
- **DO NOT** wear loose clothing while operating this machine. Roll up or button sleeves at the cuff.
- **DO NOT** sand any stock narrower than ⅛".
- **DO NOT** attempt to sand thin stock by using a "dummy" board under your workpiece.
- **DO NOT** sand stock shorter than 9".
- **DO NOT** place hands near, or in contact with, sanding drums during operation.
- **DO NOT** allow fingers to get pinched between board and conveyor belt during operation. This may pull the operator's hand into the machine and cause serious injury or death!
- **NEVER** leave the machine running unattended.
- **NEVER** operate the sander without an adequate dust collection system in place and running.
- **NEVER** sand more than one piece of stock at a time.
- **ANY PROBLEM**, with the exception of conveyor belt tracking, that is concerned at all with any moving parts or accessories must be investigated and corrected with the power disconnected, and after all moving parts have come to a complete stop. Never attempt to adjust conveyor belt tracking when the sanding drums are engaged.
- **REPLACE** sanding paper when it becomes worn.
- **ALWAYS** inspect board stock for nails, staples, knots, and other imperfections that could be dislodged and thrown from the machine during sanding operations.
- **PERFORM** machine inspections and maintenance service promptly when called for.

⚠WARNING

As with all power tools, there is danger associated with the G1066/G1066Z/G1079 Drum Sanders. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this tool with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored serious personal injury may occur.

⚠WARNING

Operating this equipment has the potential for creating flying debris which can cause eye injury. Always wear safety glasses or goggles when operating equipment. Everyday glasses or reading glasses only have impact resistant lenses, they are not safety glasses. Be certain the safety glasses you wear meet the appropriate standards of the American National Standards Institute (ANSI).

SECTION 2: CIRCUIT REQUIREMENTS

220V Single-Phase

The Model G1066/G1066Z/G1079 features 220V single-phase motors. The G1066/G1066Z 5 HP motor will safely draw about 25 amps under load. The G1079 2 HP drum motor requires 12 amps for safe operation. All sanders feature 1/4 HP feed motors that draw approx. 3 amps under load.

The Model G1066/G1066Z should be fused at 30 amps. The Model G1079 should be fused at 15 amps. Make sure the wiring in your circuit is rated to handle the amperage draw from your machine. If frequent circuit failure occurs when using the sander, contact our Service Department. The sander must be connected to its own dedicated circuit and should not share a circuit with any other machine. A standard 2-pole breaker is necessary for use with the sander.

We recommend using a NEMA-style L6-30 plug and outlet for the Model G1066/G1066Z, and an L6-15 for the Model G1079. You may also "hard-wire" the sander directly to your panel, provided you place a disconnect near the machine. Check the electrical codes in your area for specifics on wiring requirements.

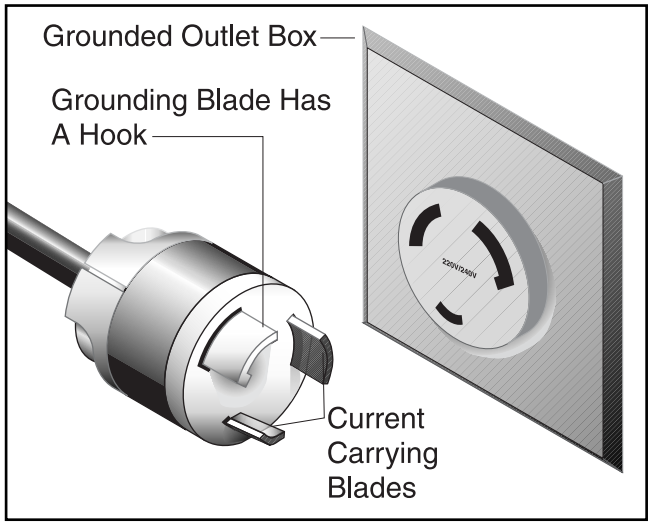
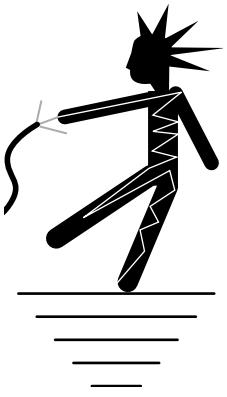


Figure 1. Typical plug configuration for 220V, single-phase operation.

Grounding

In the event of an electrical short, grounding reduces the risk of electric shock by providing a path of least resistance to disperse electric current. This tool is equipped with an electric cord that has an equipment-grounding conductor which must be properly connected to a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Improper connections of the electrical-grounding conductor can result in the risk of electric shock. The conductor with green or green and yellow striped insulation is the electrical-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment grounding conductor to a live terminal.



WARNING

This equipment must be grounded. Verify that any existing electrical outlet and circuit you intend to plug into is actually grounded. Under no circumstances should the grounding pin from any three-pronged plug be removed. Serious injury may occur.

Extension Cords

We do not recommend the use of extension cords on 220V equipment. It is much better to arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords. Should it be necessary to use an extension make sure the cord is rated Hard Service (grade S) or better. Refer to the chart in *Section 1: Safety* to determine the minimum gauge for the extension cord. The extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords when they become worn or damaged.

Wiring Diagram

The Model G1066/G1066Z/G1079 comes prewired for 220 volt operation. Wiring diagrams are provided at the back of this manual should it be necessary to repair or revise the wiring. Always consult a qualified electrician when doing any electrical work on this equipment.

⚠CAUTION

We have covered some basic electrical requirements for the safe operation of your Sander. These requirements are not necessarily comprehensive. You must be sure that your particular electrical configuration complies with local and state codes. Ensure compliance by checking with your local municipality or a licensed electrician.

SECTION 3: GENERAL INFORMATION

Commentary

We are proud to offer the Grizzly Model G1066/G1066Z/G1079 Drum Sander. Your machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

This manual covers all three models because these machines are essentially the same except for the motor size, the size of stock they can handle, the rotation of the drums and the feed rates. A number of optional accessories for these machines are available through the Grizzly catalog. Theses options include a complete selection of sanding paper, dust collection systems and a heavy-duty mobile base.

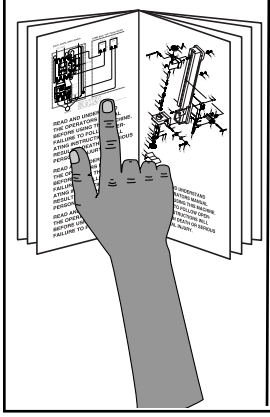
We are also pleased to provide this manual with the Model G1066/G1066Z/G1079. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible. If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
C/O Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

Most important, we stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: http://www.grizzly.com

The specifications, drawings, and photographs illustrated in this manual represent the Model G1066/G1066Z/G1079 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, we urge you to insert the new information with the old and keep it for reference.



⚠WARNING

Read the manual before assembly and operation. Become familiar with the machine and its operation before beginning any work. Serious personal injury may result if safety or operational information is not understood or followed.

Description	G1066	G1066Z	G1079
Motor Size	5 HP	5 HP	2 HP
Sanding Width	23½"	23½"	16"
Drum Rotation	With Feed	Against Feed	With Feed
Feed Rates	11 FPM	Var. 0-20 FPM	11 FPM

Unpacking

The Model G1066/G1066Z/G1079 Drum Sander is shipped from the manufacturer in a carefully packed carton. If you discover your machine is damaged after you have signed for delivery, and the truck and driver are gone, you will need to file a freight claim with the carrier. Save the containers and all packing materials for possible inspection by the carrier or its agent. Without the packing materials, filing a freight claim can be difficult. *If you need assistance determining whether you need to file a freight claim, or with the procedure to file one, please contact our Customer Service.*

⚠WARNING

The Model G1066/G1066Z/G1079 is a heavy machine (approx. 430 and 285 lb. shipping weights respectively). DO NOT over-exert yourself while unpacking or moving your machine—get assistance. In the event that your Drum Sander must be moved up or down a flight of stairs, be sure that the stairs are capable of supporting the combined weight of people and the machine. Serious personal injury may occur if they are not.

When you are completely satisfied with the condition of your shipment, you should inventory its parts.

Piece Inventory

After all the parts have been removed from the carton, you should have:

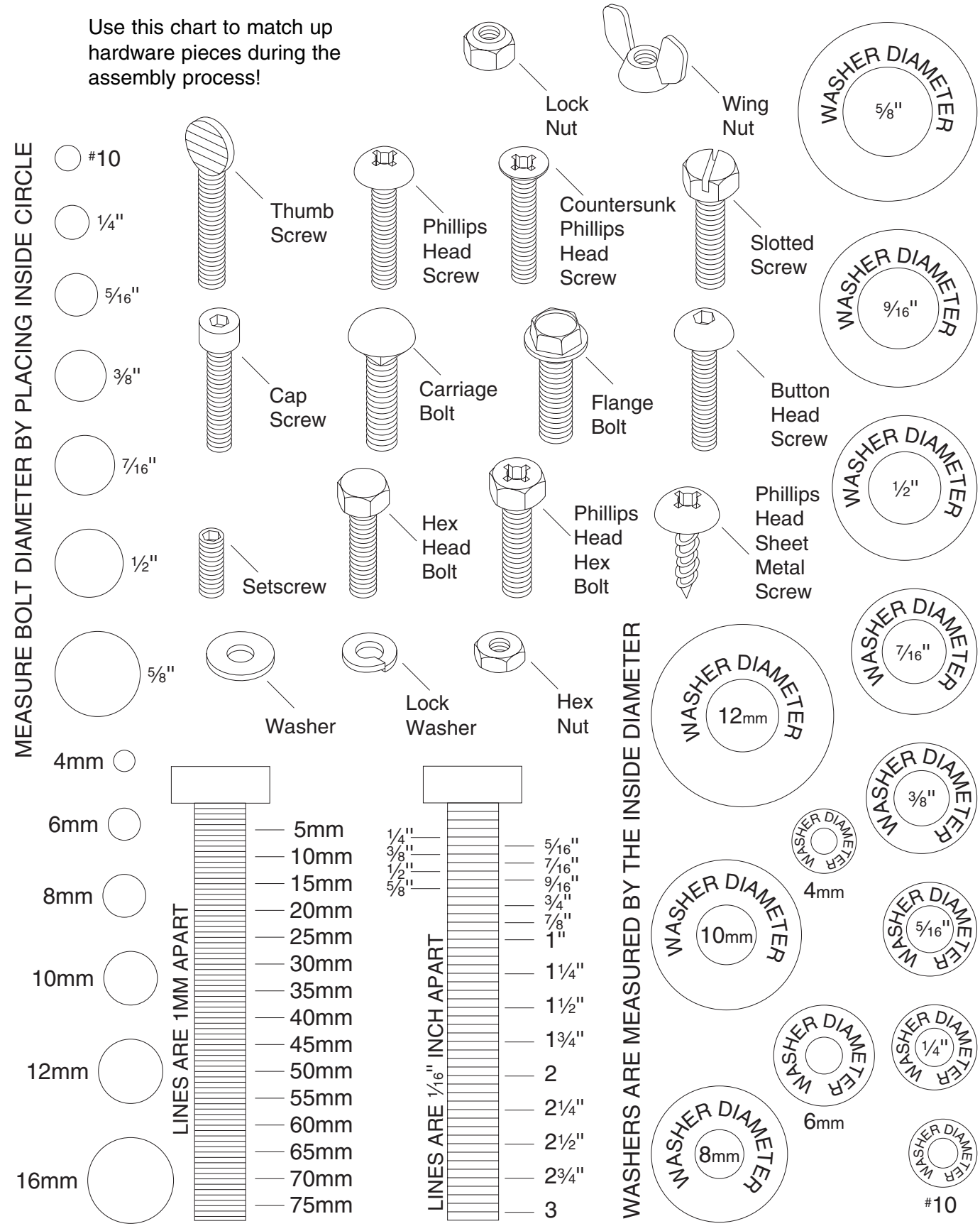
- Drum Sander Unit
- Control Panel [G1066Z]
- 4'' Dust Port (2)
- Crank Arm
- Crank Handle
- Paper Retaining Clip (2) [G1066/G1079]
- Self Tapping Screws #8 x ½" (8)
- Flat Washers #8 (8)
- 3MM Hex Wrench

In the event that any non-proprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.

NOTICE

A full parts list and breakdown can be found toward the end of this manual. For easier assembly, or to identify missing parts, please refer to the detailed illustrations at the end of the manual.

Hardware Recognition Chart



Clean Up

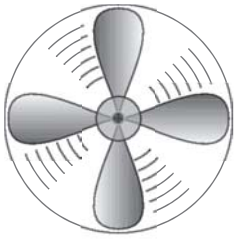
The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

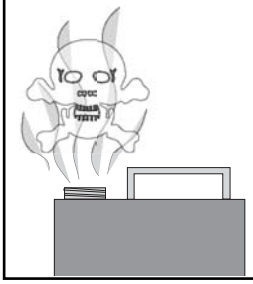
⚠WARNING

Do not use gasoline or other petroleum-based solvents to clean with. They have low flash points which make them extremely flammable. A risk of explosion and burning exists if these products are used. Serious personal injury may occur.

⚠WARNING

Do not smoke while using solvents. A risk of explosion or fire exists and may result in serious personal injury.





⚠CAUTION

Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Always work in well-ventilated areas far from potential ignition sources when dealing with solvents. Use care when disposing of waste rags and towels to be sure they do not create fire or environmental hazards.

Site Considerations

FLOOR LOAD

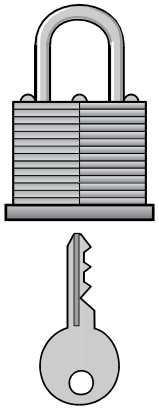
Your new drum sander represents a large weight load in a moderate sized footprint. Most shop floors will be adequate for the weight of the drum sander; however, some floors may require additional support. Contact an architect or structural engineer if you have any question about the ability of your floor to handle the weight.

WORKING CLEARANCES

Working clearances can be thought of as the distances between machines and obstacles that allow safe operation of every machine without limitation. Consider existing and anticipated machine needs, size of material to be processed through each machine, and space for auxiliary stands and/or work tables. Also consider the relative position of each machine to one another for efficient material handling. Be sure to allow yourself sufficient room to safely run your machines in any foreseeable operation.

LIGHTING AND OUTLETS

Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle combined motor amp loads. Outlets should be located near each machine so power or extension cords are not obstructing high-traffic areas. Be sure to observe local electrical codes for proper installation of new lighting, outlets or circuits.



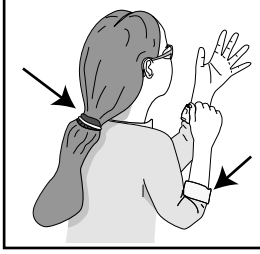
⚠CAUTION

Make your shop "child safe." Ensure that your workplace is inaccessible to children by closing and locking all entrances when you are away. Never allow visitors in your shop when assembling, adjusting or operating equipment.

SECTION 4: ASSEMBLY

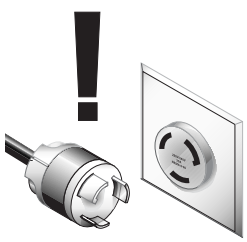
Beginning Assembly

Most of your new drum sander has been assembled at the factory, but some parts must be assembled or installed after delivery. We have organized the assembly process into steps. Please follow along in the order presented in this section.



⚠WARNING

Keep loose clothing out of the way of machinery and keep hair pulled back.



⚠WARNING

Disconnect power to the machine when performing any maintenance or assembly. Failure to do this may result in serious personal injury.

⚠WARNING

Wear safety glasses during the entire assembly process. Failure to comply may result in serious personal injury.

⚠CAUTION

Some metal parts may have sharp edges on them after they are formed. Please examine the edges of all metal parts before handling them. Failure to do so could result in injury.

Dust Ports

The Model G1066/G1079 Drum Sander comes equipped with two 4" dust ports as shown in **Figure 2**. Apply double sided tape between the plastic dust ports and the sheet metal cover, then secure in place with sheet metal screws.

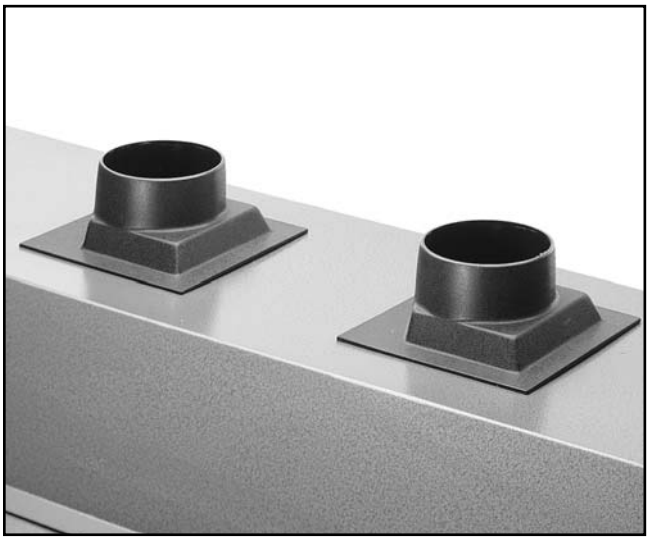


Figure 2. Top-mounted 4" dust ports.

The Model G1066Z also comes equipped with two 4" dust ports, but these mount in the center of the top and the center of the front on the sheet metal cover. As with the other models, apply double sided tape between the plastic dust ports and the sheet metal cover, then secure in place with sheet metal screws.

⚠CAUTION

DO NOT operate the Model G1066/G1066Z/G1079 without an adequate dust collection system. This machine creates substantial amounts of wood dust while in operation. Failure to use a dust collection system can result in short and long-term respiratory illness.

Crank Handle

The crank handle is normally installed on the front right lead screw shaft, and is held in place with two setscrews already threaded into the handle, as shown in **Figure 3**. The crank handle can be installed on the right or left side of the machine to maximize operator comfort and convenience.

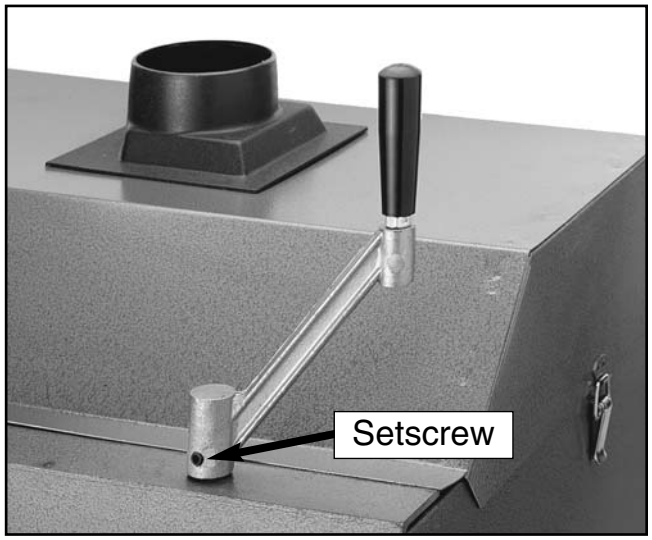


Figure 3. Crank handle attachment.

G1066Z Control Panel

To mount the control panel to the base unit on the Model G1066Z:

1. Match the holes in the control arm mounting plate to the threaded holes on the side of the the sander.

2. Use the 5/16"-18 x 1" hex bolts and washers to secure the control arm to the sander body as shown in **Figure 4**.

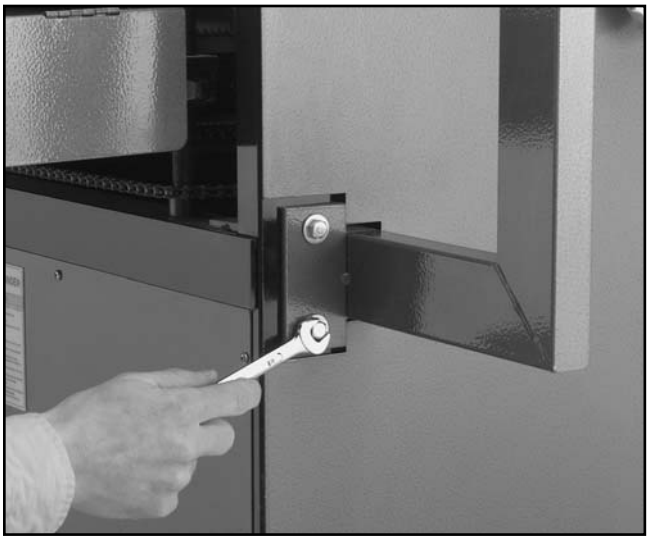
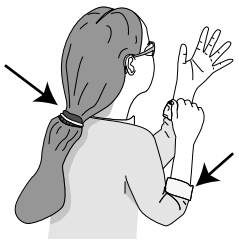


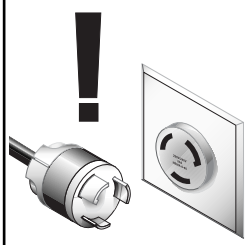
Figure 4. Control panel attached to base unit.

SECTION 5: ADJUSTMENTS



⚠WARNING

Keep loose clothing out of the way of machinery and keep hair pulled back.



⚠WARNING

Disconnect power to the machine when performing any adjustments or maintenance. Failure to do this may result in serious personal injury.

⚠WARNING

Wear safety glasses during the entire adjustment process. Failure to comply may result in serious personal injury.

Drum Alignment

For the Model G1066/G1066Z/G1079 Drum Sander to function properly, the sanding drums must be aligned in two directions: (1) perpendicular to feed direction (**Figures 5 and 6**) and (2) parallel to the conveyor belt.

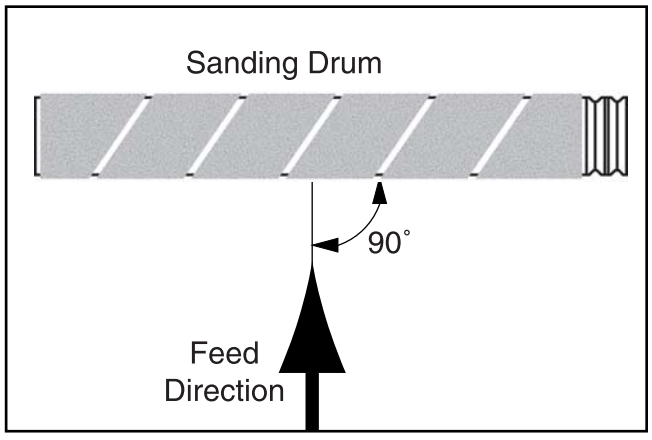


Figure 5. Feed direction perpendicular to drum.

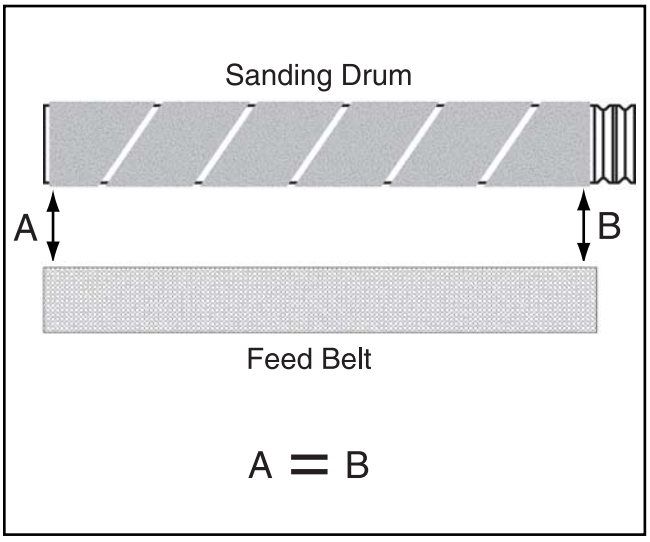


Figure 6. Sanding drum parallel to feed belt.

In order to make the above adjustments, it is necessary to know how to adjust the bearing blocks.

To adjust the Model G1066/G1066Z/G1079 bearing blocks:

1. Loosen the lock nuts (**See Figure 7**) on one of the bearing blocks on the drum that requires adjustment.

2. Raise or lower the bearing block by rotating the setscrews (**See Figure 7**). *Turn very gradually ⅛ of a turn or less.*

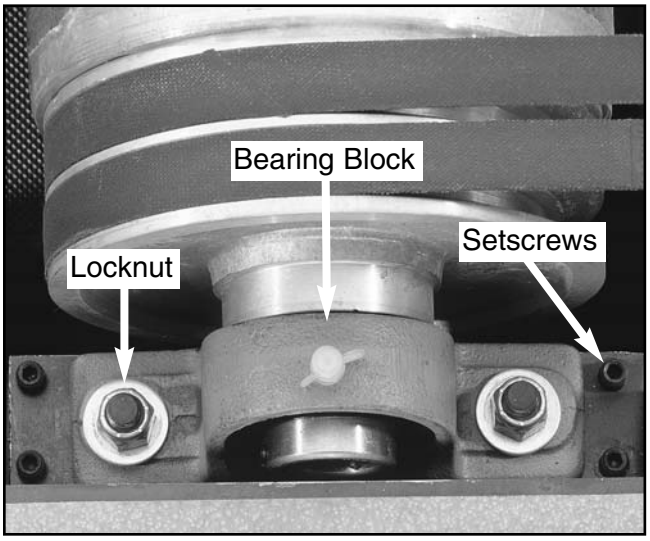


Figure 7. Bearing block adjustments.

3. Tighten the lock nuts and recheck the alignment using the same hardwood block. Tightening the lock nuts will pull the drum downward slightly. Be sure to adjust to compensate for this movement. **Do not over tighten the lock nuts. The bearing blocks can break if over tightened.**

4. For Models G1066/G1079 repeat **steps 1-3** for the other drum. Tighten the lock nuts. Model G1066Z has micro-adjustment knobs on the sides of the machine for rear drum adjustments. See **Figure 9**. Both drums should now be properly adjusted. **Do not change the table height until the lock nuts are tight.**

   Use care when tightening lock nuts. While they are made of durable cast metal, the bearing blocks are susceptible to breakage if the metal is fatigued by excess tension caused by overtightening.

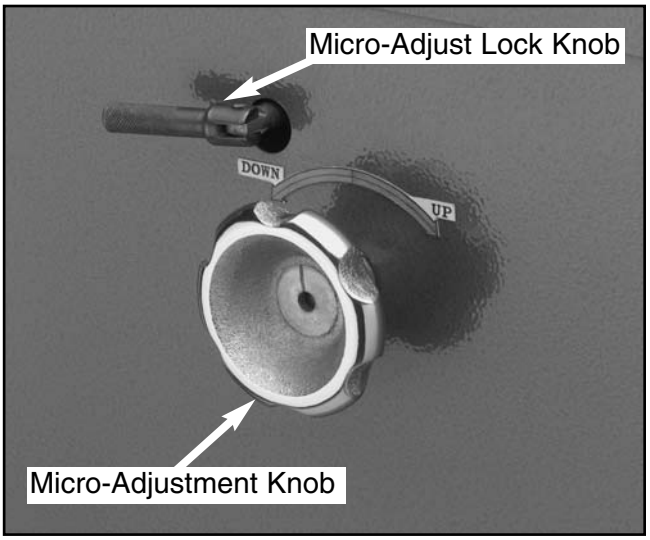


Figure 9. Model G1066Z rear drum adjustment control.

To adjust the drums perpendicular to the feed direction:

1. **Disconnect the sander from the power source!**

2. First measure the distance between the outside of the front drum and the inside of the front brace. The distances should be within ⅛" of each other at each end of the drum.

3. Repeat the measurements with the rear drum and brace. If the measurements are not within ⅛", the drums can be moved by loosening the lock nuts on the bearing blocks and moving one end of the drum forward or backward as necessary in the slotted holes. *If the drums are not perpendicular to feed direction, the sandpaper will creep toward one end of the drum. After you have adjusted the drums, do not forget to tighten the lock nuts and recheck the alignment.*

To adjust the drums parallel to the conveyor belt:

1. **Disconnect the sander from the power source!**

2. For this step, you will need a 24" long block of wood. A quality 2x4 will work fine (**See Figure 10).**

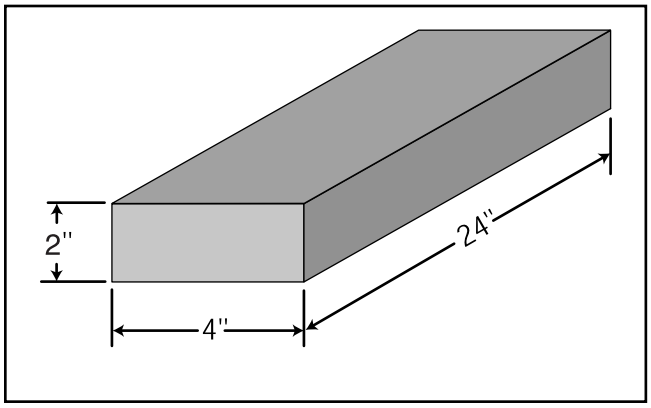


Figure 10. Dimensions of gauge block.

3. Start with the front sanding drum. Lower the table so the block will slide easily under the pressure bars. Slide the block over to one side of the table, with the front edge lined up to the front of the table. (It is important to line up the block carefully to ensure that the same part of the 2x4 is used to set the drum heights.) Raise the table up so the board barely touches the front pressure roller.

4. Raise the table one full turn of the handwheel. Adjust the height of that side of the front sanding drum so it just touches the board and is able to rock back and forth with moderate resistance.

5. Stop and mark the location of the table elevation handle with a felt pen or piece of tape. In the same manner, mark the height of the table in relation to the body of the sander. Both of these marks will indicate this exact table position (we will refer to it as reference height #1). Having reference height #1 marked is crucial to all subsequent steps.

6. Lower the table exactly 2 turns. Remove the block and re-insert it on the other side, taking care to line it up with the front of the table just as it was on the previous side. Raise the table exactly 2 turns to bring it back up to reference height #1.

7. Set the height of that end of the drum to the board. Rock the drum back and forth again. It should feel and sound the same as it did on the other end. If the sound and rolling action are not identical, adjust the bearing block height. Continue this procedure, going back and forth, until both sides of the drum sound and feel the same.

8. To adjust the rear drum, lower the table by turning the handwheel counter-clockwise 1/8th of a turn from reference #1. Make a second mark. This will be reference #2 and will be used for setting up the rear drums.

9. Repeat **steps 5-6** until both sides of the rear drum are the same. (Note: the G1066Z has external height adjustment knobs for the rear drum. These are located on each side of the machine. Other than this difference, the procedure for setting the drum height is the same.)

10. While the rear drum should always be slightly lower than the front drum, the actual difference will vary depending on wood type, feed rate, sandpaper grits, etc. Once you are familiar and comfortable with the adjustment procedures, you should experiment to arrive at the best settings for your specific application.

⚠CAUTION

In addition to premature wear and failure of sandpaper, improper drum alignment could cause the possibility of an uncontrolled exit of material from the machine—which could result in damage to property or potential operator injury.

Pressure Rollers

The spring tension of the pressure rollers can be adjusted to reduce snipe. (Note: roller pressure is also affected by the drum height.)

To adjust the pressure rollers:

1. **Disconnect the sander from the power source!**

2. Remove sanding head cover (disconnect dust collector hose if attached).

3. Loosen the jamnuts on the hex bolts. Turn the hex bolts downward to increase the pressure roller spring tension. See **Figure 11.** Increasing the tension will increase the pressure of the board on the conveyor belt, but will also be less forgiving of irregularities in the board and could cause jamming. You will need to determine experimentally the optimal tension for your stock.

4. Replace the sanding head cover and reconnect the dust collector.

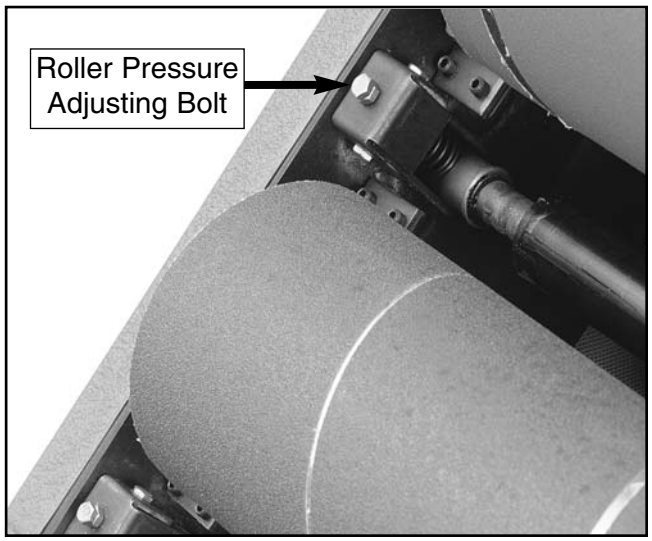


Figure 11. Location of pressure roller tensioners.

To provide increased operator control, the Model G1066Z features height adjustment controls for the feed roller. These controls are located on the underside of the roller pressure spring controls and consist of a hex bolt and jamnut setup, exactly like the roller pressure spring tension controls.

To adjust the pressure roller height on the Model G1066Z:

1. **Disconnect sander from the power source!**

2. The “Drum Alignment” instructions must be followed before this adjustment can be performed. Use the same 2x4 for this procedure.

3. With the 2x4 in place on one end of the table, raise the table up to reference height #1.

4. Lower the table 1 full turn with the handwheel.

5. On the same side as the 2x4, loosen the jamnuts on the roller height hex bolts.

6. Adjust all 3 pressure rollers by turning the hex bolts. The pressure rollers should barely touch the surface of the 2x4, allowing just enough room to rotate. At this position, tighten the jamnut on the bolt so it does not move.

7. Repeat **steps 3-6** with the other side to make sure all pressure rollers are even and parallel to the table.

These adjustments should be used as a starting point. Once you are familiar and comfortable with the adjustment procedures, you should experiment to arrive at the best settings for your specific application.

Dust Scoop

The Model G1066/G1079 is equipped with a dust scoop located next to the rear sanding drum. The Model G1066Z features a dust scoop for each drum. Dust scoops reduce the amount of dust that accumulates on the workpiece as it travels through the sander. Dust scoops are adjustable and should be set approximately 1/32" above the bottom of the rear drum for optimum effectiveness.

To adjust a dust scoop:

1. **Unplug the sander from its power source!**

2. Place two 2x4's of equal height under the rear sanding drum and the dust scoop. Raise the table until the 2x4's just touch the drum.

3. Loosen the dust scoop mounting bolts located at each end of the scoop as shown in **Figure 12.**

4. Move the scoop up or down until it is approximately 1/32" above the 2x4's. Some flexing of the sheet metal assembly may be needed to get the proper clearance. Retighten the mounting bolts and remove the 2x4's.

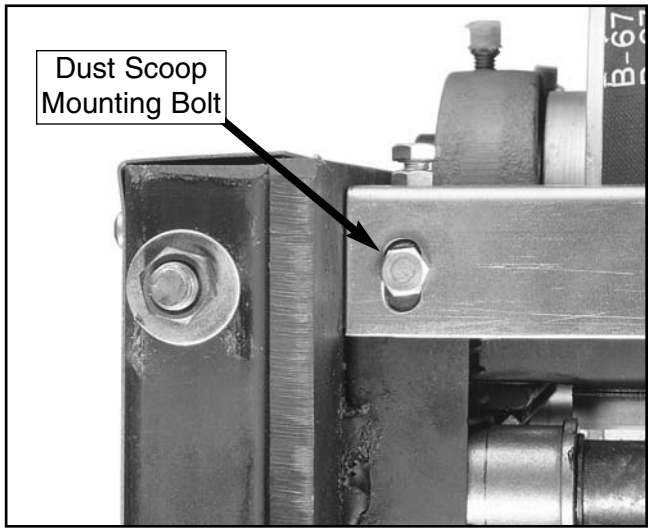


Figure 12. Location of dust scoop bolts.

V-Belt

The sanding drums are driven by two V-Belts on the Models G1066 & G1066Z and one V-Belt on the Model G1079. The V-Belts must have proper tension for proper power transmission. Proper tension is achieved when the V-Belts can be deflected about 3/4" with moderate finger pressure at the midpoint between the drum sheaves (sheaves are integral on the Model G1079) and the motor sheave. To adjust V-Belt tension, loosen the motor mounting bolts and slide the motor accordingly. Ensure that the pulleys stay in line with each other and tighten the motor mounting bolts. Re-check V-Belt tension and alignment.

To check alignment, ensure that the machine is on a level floor. Hold a straightedge against the side of the rear contact drum sheave. The contact drum and motor sheaves are in alignment when the straightedge also barely touches the side of the motor sheave.

To align the sheaves, loosen the motor from the motor mounting plate and shift the motor in the desired direction. Tighten the motor mount bolts and re-check alignment and tension.

If the sheaves will not come into alignment by adjusting the motor, the motor sheave can be moved directly along the motor shaft. Loosen the setscrew on the motor sheave and move it in or out accordingly.

⚠ CAUTION

Always inspect V-belts for damage or deterioration when adjusting for tension or alignment. Should you find evidence of cracking, abrasion or damage from wood chips or other foreign materials, replace the belt immediately. Belt breakage could lead to mechanical damage or operator injury.

Paper Replacement G1066/G1079

The Model G1066/G1079 is designed for 6" wide sandpaper rolls. The outfeed sanding drum is wrapped in felt to slightly increase the drum diameter and to provide a smooth sanded surface. The felt should be 1" from the edge of the drum to allow room for the tape to adhere.

To change the paper:

1. **Disconnect the machine from the power!**

2. Take the sheet metal cover off.

3. Remove the tape from around the right side of the drum and the clip that attaches the sandpaper to the left side of the drum (**See Figure 13**).

⚠CAUTION

Be careful that the tension wheel does not pinch your fingers when the pressure is released and it snaps back to a relaxed position.

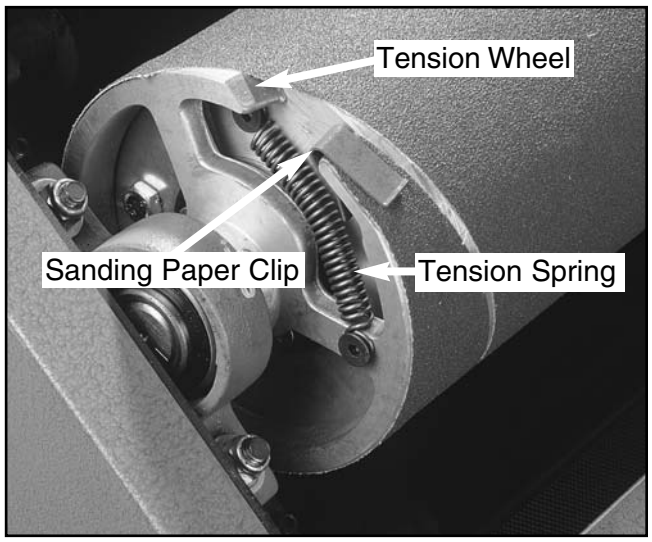


Figure 13. Sanding paper attachment.

4. Unwind the old sandpaper and use it as a pattern or use the pattern in **Figure 14** to cut a piece of 6" wide sandpaper of the desired grit. It is necessary to cut a triangular portion of the paper away at each end.

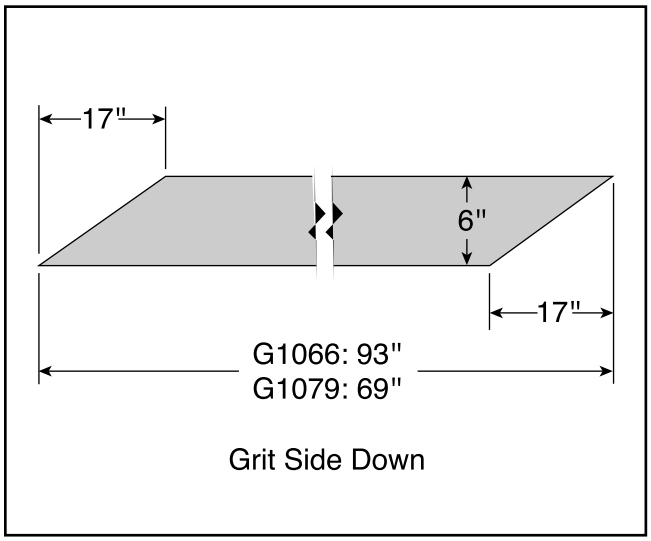


Figure 14. Illustrates paper preparation.

5. Starting at the left side of the drum, fold the corner of the sandpaper into the spring clip, then install the clip onto the tensioner. You may need to tap the clip with a hammer or mallet to ensure that it is seated; however, you do not have to drive clip completely on, just make sure it is secure. Too much force will break the clip! Also, do not fold paper over tensioner and then install the clip—the paper may tear as a result.

6. Pull the paper until the tension wheel spring has bottomed out in its travel.

7. *This step is possible to accomplish alone, but it is easier with an assistant*. While one person rolls the drum, the other tightly spirals the paper onto the drum, ensuring that there are no bubbles or overlapping edges. **IMPORTANT:** Try to leave a uniform 3⁄16" gap between the spirals as you wind the paper around the drum. This will allow the paper to move and stretch slightly and will decrease the likelihood of tearing and overlapping.

8. Hold the loose end against the right side of the contact drum and wrap with duct tape to secure. Double-check the drum to make sure there are no bubbles or overlapping edges and your gapping is correct.

9. Repeat steps 1-6 for the other drum.

10. Mount the hood and reconnect the flex-hose to the dust collection ports.

Important Tips For Changing Sandpaper

- Replace the paper on each drum individually. Once paper is removed from both drums, they can be slippery and hard to rotate.
- Always fold the paper into the spring clip and then insert it.
- The spring clip does not have to be driven completely on.
- Changing sandpaper is easier with the help of another person.

Paper Replacement G1066Z

The Model G1066Z is designed for 3" wide hook and loop sandpaper rolls.

To change sandpaper on the G1066Z:

1. **Disconnect the sander from the power source!**

2. Remove the top cover to expose the drums.

3. One drum at a time, unwind the old sandpaper and notice the direction that it was wrapped around the drum.

4. Use the old sandpaper as a pattern to cut out the new sandpaper.

5. Wrap the sanding drum with the new sandpaper. Make sure to wrap the sandpaper tight and try to keep the gaps to a minimum.

6. Tape both ends with ¾" strapping tape, making at least two complete passes so that the second layer is directly on top of the first. See **Figure 15**. Repeat **steps 3-5** with the other drum.

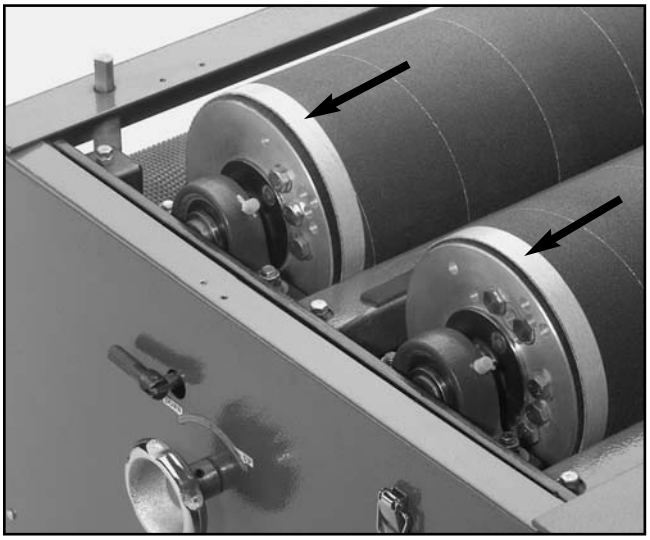


Figure 15. Sandpaper ends taped on Model G1066Z.

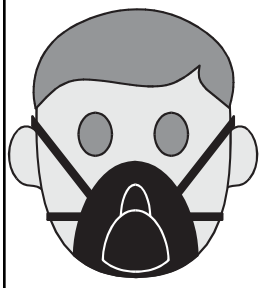
Dust Collection

The dust collection ports are located on the top of the sanding head cover and each measures 4" in diameter. It will be necessary to attach 4" dust collection pipes over these ports. Flex-hose is recommended because it will ease removal of the sanding head cover when paper changes and adjustments are necessary. Grizzly offers 4" flex-hose to connect this machine to a dust collection system. The flex-hose easily attaches with a 4" hose clamp. Please refer to our catalog for current price and ordering information.

Your dust collector must be able to move 450 cfm at the Drum Sander. If you have a remotely located dust collector or you are operating more than one machine at a time, ensure that your dust collector has the capacity and power to meet this requirement. A fine layer of dust will be present on your stock as it comes out of the sander. This is normal.

⚠CAUTION

DO NOT operate the Model G1066/G1066Z/G1079 without an adequate dust collection system. This machine creates substantial amounts of wood dust while in operation. Failure to use a dust collection system can result in short and long-term respiratory illness.



⚠CAUTION

Always wear a dust mask in addition to using a dust collector. Dust masks filter out the smaller particles of dust that dust collectors cannot trap.

Conveyor Belt

The conveyor belt tension and tracking adjustments are controlled by the adjustment bolts located at each end of the front and rear conveyor rollers. If the conveyor belt is too loose or tracks off to one side, adjust as follows:

1. If the conveyor belt is slipping, turn both **infeed** adjustment bolts counter-clockwise. **See Figure 16.**

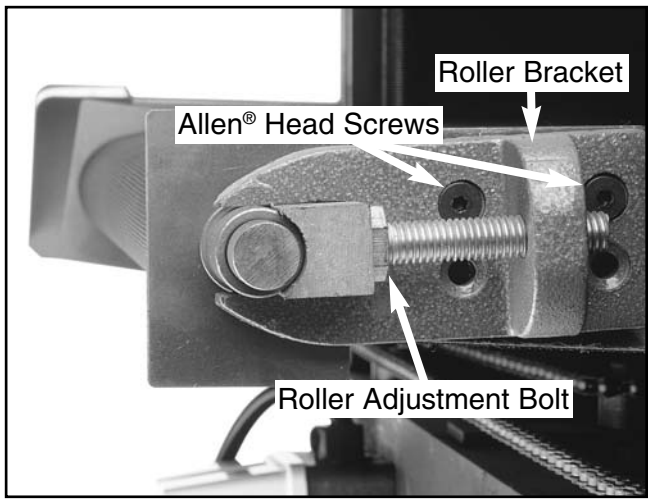


Figure 16. Location of conveyor adjustments.

2. If the conveyor belt tracks toward the right side, turn the adjustment bolt located at the infeed right corner. Turning this bolt counter-clockwise will make the sanding belt move to the left.

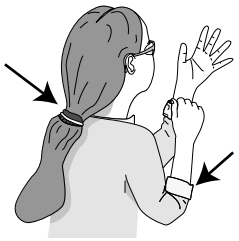
3. After you have made the adjustment, run the machine for approximately 15 minutes to observe the tracking adjustment you made. Be patient, the belt tracks slow.

4. If the conveyor belt tracks too far to the left, loosen the adjustment bolt. Turning this bolt clockwise will move the sanding belt to the right.

⚠WARNING

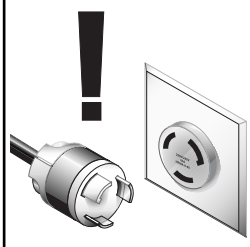
Always make adjustments at the infeed end to avoid re-adjusting conveyor drive chain. Conveyor belt tracking adjustments must be made while the conveyor belt is running. Use extreme care to ensure that clothing, hair or jewelry is kept safely away from moving parts.

SECTION 6: OPERATIONS



⚠WARNING

Keep loose clothing out of the way of machinery and keep hair pulled back.

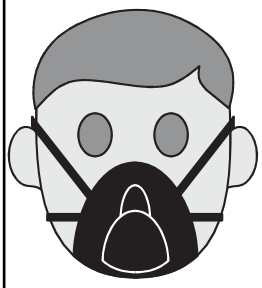


⚠WARNING

Disconnect power to the machine when performing any adjustments or maintenance. Failure to do this may result in serious personal injury.

⚠WARNING

Wear safety glasses during all operations on the planer. Failure to comply may result in serious personal injury.



⚠CAUTION

Always wear a dust mask when operating the sander. Using this machine produces sawdust which may cause allergic reactions or respiratory problems.

NOTICE

The following section was designed to give instructions on the basic operations of this drum sander. However, it is in no way comprehensive of every drum sander application. WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training to maximize the potential of your drum sander.

G1066Z Control Panel

Before plugging in the Model G1066Z familiarize yourself with the control panel.

The Model G1066Z control panel features a main power switch, separate on/off controls for the variable speed conveyor and the sanding drums, a variable speed adjustment dial and an amp load meter. **Figure 17** points out each of these controls.

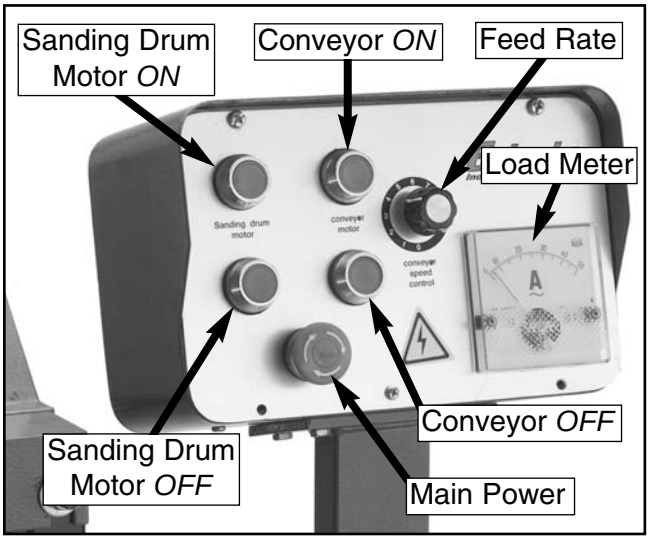


Figure 17. G1066Z control panel.

The main power switch features an important safety device that is very important to remember. A twist-and-pull design in the knob helps to avoid accidental starts; yet, in the event of an emergency, the knob can be pushed straight down to stop the machine.

Another important point to remember about the control panel is that the feed conveyor motor and the drum motor operate independently from each other.

The load meter and the variable speed dial are very important to the operation of the Model G1066Z. Please read the “Load Meter” and the “Variable Speed” instructions in this section before sanding any stock.

Test Run

Once the assembly is complete and the adjustments are done to your satisfaction, you are ready to test the machine.

Turn on the power supply at the main panel. Press the *START* button. Make sure that your finger is poised on the *STOP* button, just in case there is a problem. The drum sander should run smoothly, with little or no vibration or rubbing noises. Strange or unnatural noises should be investigated and corrected before operating the machine further. To avoid injury or damage to the machine, **DO NOT** attempt to make adjustments to the machine without turning it off and unplugging it from its power source.

If noises occur that cannot be found by visual inspection, feel free to contact our Service Department for help.

⚠WARNING

DO NOT attempt to investigate or adjust any features of the machine while it is running. Wait until the machine is turned off, unplugged and all working parts have come to a rest before you do anything! Failure to do so could result in severe injury or damage to equipment.

⚠WARNING

DO NOT sand more than one board at a time. Minor variations in thickness can cause one board to be propelled by the rapidly spinning sanding drum and ejected from the machine. NEVER stand directly in front of the outfeed area of the machine. Failure to do so could result in severe personal injury.

G1066/G1079

Your new Model G1066/G1079 Drum Sander is a relatively simple piece of equipment to set up and run. Under most sanding conditions, a normal cut is no more than 1/64". This depth can be achieved by approximately ¼ turn of the table height handle. Attempts to remove too much can cause jamming, wood burning, rapid paper wear or tearing, poor finish and belt slippage. We recommend that wide stock be sent through two to three times without adjusting the table height. Turn the stock 180° to ensure an even cut. The following is the correct start-up and operating procedure for either of these machines.

1. Start the dust collector.

2. Make thickness adjustment. Place workpiece on the conveyor table and turn the table handle until the workpiece can be sanded and fed through smoothly. Turning the handle clockwise will raise the conveyor table. Turning the table handle counter-clockwise will lower the conveyor table.

3. Remove the workpiece from the conveyor belt.

4. Start the Drum Sander and feed your stock. Retrieve by standing at the side–not at the outfeed end.

5. Check the sanded piece. Is the piece smooth? Mark a squiggly pencil line on a board and sand it to test for even sanding. Look for uniform removal of the line. If the line is not removed uniformly, refer to the adjustment section earlier in the instruction manual.

NOTICE

We strongly recommend sending wide stock through the sander two or three times without adjusting the height. This is an important method for preventing burning your wood or ruining sandpaper.

G1066Z

Your new Model G1066Z Drum Sander provides a great amount of operator control during operation. To utilize this control, you should be familiar with the variable speed and the load meter before using the drum sander.

Variable Speed

The variable speed dial located on the control panel allows you to increase the feed rate from 0-20 FPM. The correct speed to use depends on the type of stock you are using (hardwood vs. softwood) and the stage of finish you are at with that stock.

As a general rule, a slower feed rate will sand the surface smoother, but runs the risk of burning the wood; a faster feed rate will remove material faster, but runs the risk of overloading the motor. Use trial-and-error to determine the best settings for your specific applications.

Load Meter

The load meter located on the control panel displays the current amperage draw of the drum motor. The needle rises when you increase the load on the sanding drums and decreases when you decrease the load. Use this meter to avoid overloading your machine with too heavy of a cut. **NEVER exceed 25 amps—this is the maximum that your machine can safely handle!**

Since various types of stock will react differently with various loads, use trial-and-error to determine the best settings for your applications. As a general rule, always start with a small load and work your way up. We recommend that you do not push your machine to its maximum load; instead, make multiple passes or install a coarser grit paper.

Operation

Under most sanding conditions, a normal cut is no more than 1/64". This depth can be achieved by approximately 1/4 turn of the handle. Excessively heavy cuts can cause jamming, wood burning, rapid paper wear, poor finish and belt slippage.

We recommend that wide stock be sent through two to three times without adjusting the table height—this is important for preventing burned wood or ruined sandpaper. Also, turn the stock 180° to ensure an even cut. The following is the correct start-up and operating procedure for this model.

1. Start the dust collector.

2. Place stock on the conveyor table and turn the table handle to raise the conveyor table until the stock barely touches the pressure bar.

3. Start the drum motor and the feed motor. Pass the stock through the sander and slowly raise the conveyor table while listening for stock-to-drum contact. As soon as you hear contact, stop raising the table and watch the load meter (if it gets too high, immediately lower the conveyor table). Retrieve your workpiece by standing to the side of the sander—NOT directly behind it.

4. Without moving the table, make multiple passes and check your workpiece.

5. Check the sanded piece. Is the piece smooth? Mark a squiggly pencil line on a board and sand it to test for even sanding. Look for uniform removal of the line. If the line is not removed uniformly, refer to the *Adjustments* section earlier in the instruction manual.

Hook & Loop Sandpaper

Although hook & loop sandpaper is convenient and easy to install, care must be taken not to overload it while sanding by taking excessively heavy cuts.

Excessively heavy cuts will cause the underlying hooks and loops to slightly depress and deform under the sandpaper, resulting in small surface grooves and ridges on all subsequently sanded pieces. If this should happen, the only way to correct the situation is to unwrap and then re-wrap the sandpaper around the drum to “reset” the hooks and loops.

Simply stated: DO NOT take excessively heavy cuts. If you need to remove material faster, switch to a coarser grit of sandpaper.

Choosing Sandpaper

There are many types of sanding belts to choose from. We recommend Aluminum Oxide for general workshop environments. Below is a chart that groups abrasives into different classes, and shows which grits fall into each class.

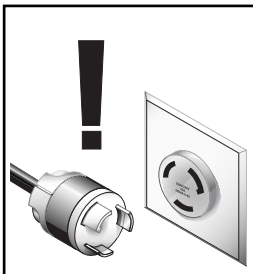
Grit	Type
60	Coarse
80-100	Medium
120-180	Fine
220	Very Fine

The general rule of thumb is to sand a workpiece with progressively higher grit numbers, with no one grit increase of more than 50.

The Model G1066/G1066Z/G1079 allows you to place two different grit sandpapers on each drum.The first drum should have a coarser grit than the second. Usually this translates into combinations of successive group types. A common selection for stock that is planed before being sanded is a 100/150 grit combination.

Ultimately, the type of wood you use and your stage of finish will determine the best grit types to install on your sander.

SECTION 7: MAINTENANCE



WARNING

Disconnect power to the machine when performing any adjustments or maintenance. Failure to do this may result in serious personal injury.

General

Make a habit of inspecting your Model G1066/G1066Z/G1079 each time you use it. Check for the following conditions and repair or replace when necessary.

- Loose mounting bolts.
- Worn switch.
- Worn or damaged cords and plugs.
- Damaged V-belt.
- Any other condition that could hamper the safe operation of this machine.

WARNING

DO NOT attempt to investigate or adjust any features of the machine while it is running. Wait until the machine is turned off, unplugged and all working parts have come to a rest before you do anything!

Lubrication

Bearing blocks must be lubricated every 20 hours of operation. Use a high-quality, lithium-based grease. The grease fittings are located on the top of each bearing block.

Other moving parts such as chains should be lubricated periodically with a light machine oil. Motor bearings need no lubrication.

Use only adequate lubrication. Too much lubricant will attract dirt and sawdust and will clog the chain mechanism.

CAUTION

Failure to routinely inspect your drum sander for damage and wear could result in unsatisfactory work results, premature component or machinery failure, or operator injury. We recommend you create a checklist for routine inspection and maintenance. Remember to always disconnect the drum sander from its power source before attempting to inspect, adjust, or repair this machine!

Bearing Replacement

The tools necessary for this job are a large round shaft screwdriver and a bench vise. Replace bearing as follows:

1. Remove the roller housing from the drum sander and clamp it tightly in a bench vise.

2. Insert the screwdriver into the center hole of the bearing as shown in **Figure 18.** Lever the bearing until it turns perpendicular to the housing. Once the bearing is turned 90° from the housing, it should slide free with little effort. The housing is designed with notches that allow the bearing to be inserted and removed. It is important that you lever the bearing so it turns in alignment to those notches.

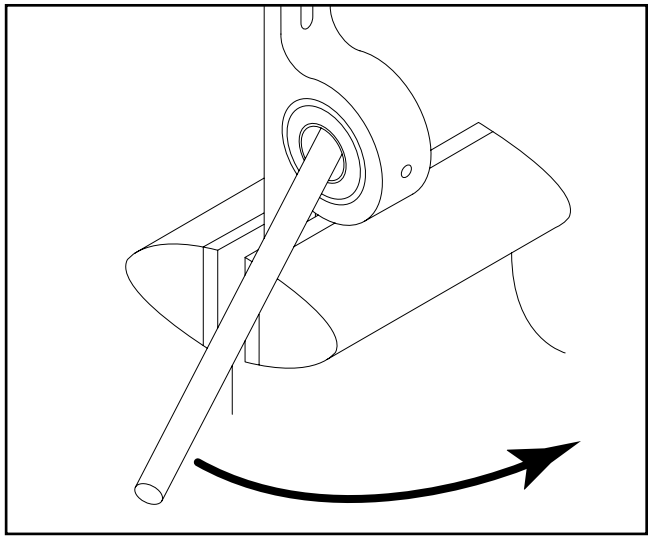


Figure 18. Detaching bearing from housing.

3. Once the old bearing is removed, clean the bearing housing. Insert the new bearing into the notches in the housing as shown in **Figure 19.** Twist the bearing clockwise 90° after it reaches into the housing as far as it will go as shown in **Figure 20.**

4. Insert the screwdriver through the bearing, as in **step 2** and lever the bearing into its proper position in the housing.

5. Press or tap the bearing and housing back into place on the drum shaft. Re-adjust the drum as necessary.

NOTICE

Make sure, when installing the new bearing, that the lubrication groove in the bearing will match the groove and grease fitting in the housing once it is in place.

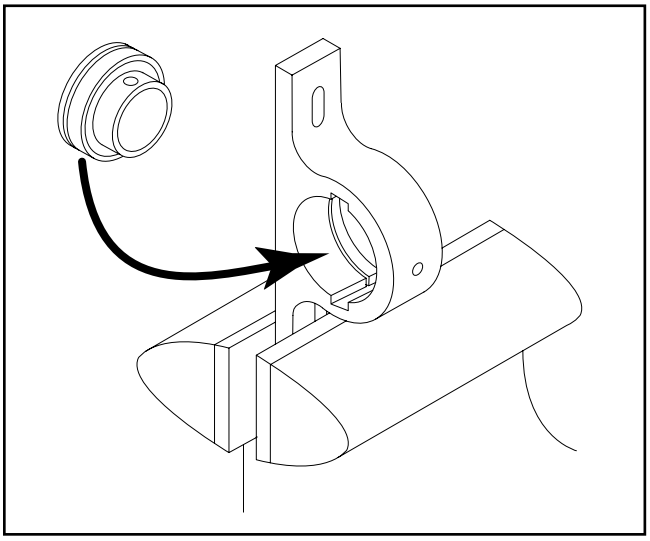


Figure 19. Matching bearing tab to notch.

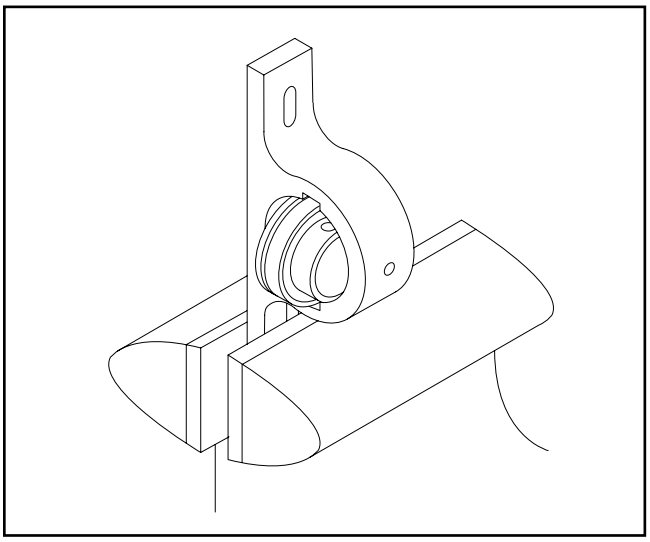


Figure 20. Inserting bearing into housing.

6. Re-attach the sanding head cover before operating the sander.

NOTICE

Lubricate the bearings sparingly after about two months of sander operation. The bearing requires very little grease, so avoid the temptation to over-lubricate.

SECTION 8: CLOSURE

The following pages contain general machine data, parts diagrams/lists, troubleshooting guide and Warranty/Return information for your Model G1066/G1066Z/G1079 Drum Sanders.

If you need parts or help in assembling your machine, or if you need operational information, we encourage you to call our Service Department. Our trained service technicians will be glad to help you.

If you have comments dealing specifically with this manual, please write to our Bellingham, Washington location using the address in *Section 3: General Information*. The specifications, drawings, and photographs illustrated in this manual represent the Model G1066/G1066Z/G1079 as supplied when the manual was prepared. However, due to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, add the new information to this manual and keep it for reference.

We have included some important safety measures that are essential to this machine's operation. While most safety measures are generally universal, Grizzly reminds you that each workshop is different and safety rules should be considered *as they apply to your specific situation.*

⚠WARNING

This equipment has the potential to create flying debris which can cause severe eye injury. Always wear safety glasses or goggles when operating equipment. Everyday glasses or reading glasses only have impact resistant lenses, they are not safety glasses. Be certain the safety glasses you wear meet the appropriate standards of the American National Standards Institute (ANSI).

We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to this machine, or if you need general assistance or replacement parts, please contact the Service Department listed in *Section 3: General Information*.

Additional information sources are necessary to realize the full potential of this machine. Trade journals, woodworking magazines, and your local library are good places to start.

⚠WARNING

The Models G1066/G1066Z/G1079 were specifically designed for sanding wood. DO NOT MODIFY AND/OR USE THESE MACHINES FOR ANY OTHER PURPOSE. Modifications or improper use of this tool will void the warranty. If you are confused about any aspect of this machine, DO NOT use it until you have answered all your questions. Serious personal injury may occur.

⚠WARNING

Like all power tools, there is danger associated with the Model G1066/G1066Z/G1079 Drum Sanders. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this tool with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

MACHINE DATA SHEET

Customer Service #: (570) 326-3806 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G1066 DRUM SANDER

Design Type .....Floor Model

Overall Dimensions:
- Height .....43"
- Width.....34½"
- Depth .....37"
- Shipping Weight.....430 lbs.
- Net Weight .....389 lbs.
- Crate Size .....39½" L x 41" W x 44" H
- Footprint .....34½" x 24"

Capacities:
- Maximum Board Width .....23½"
- Maximum Board Thickness .....4¼"
- Minimum Board Length ..... 9"
- Minimum Board Thickness .....⅛"
- Diameter of Drum .....6"
- Surface Speed of Drums .....2300 FPM
- Conveyor Feed Rate .....11 FPM

Sanding Drum Motor:
- Type .....TEFC Capacitor
- Horsepower.....5 HP
- Voltage .....220V ONLY
- Amps.....25
- RPM 3450
- Phase / Cycle .....Single / 60 HZ
- Power Transfer .....Belt Drive

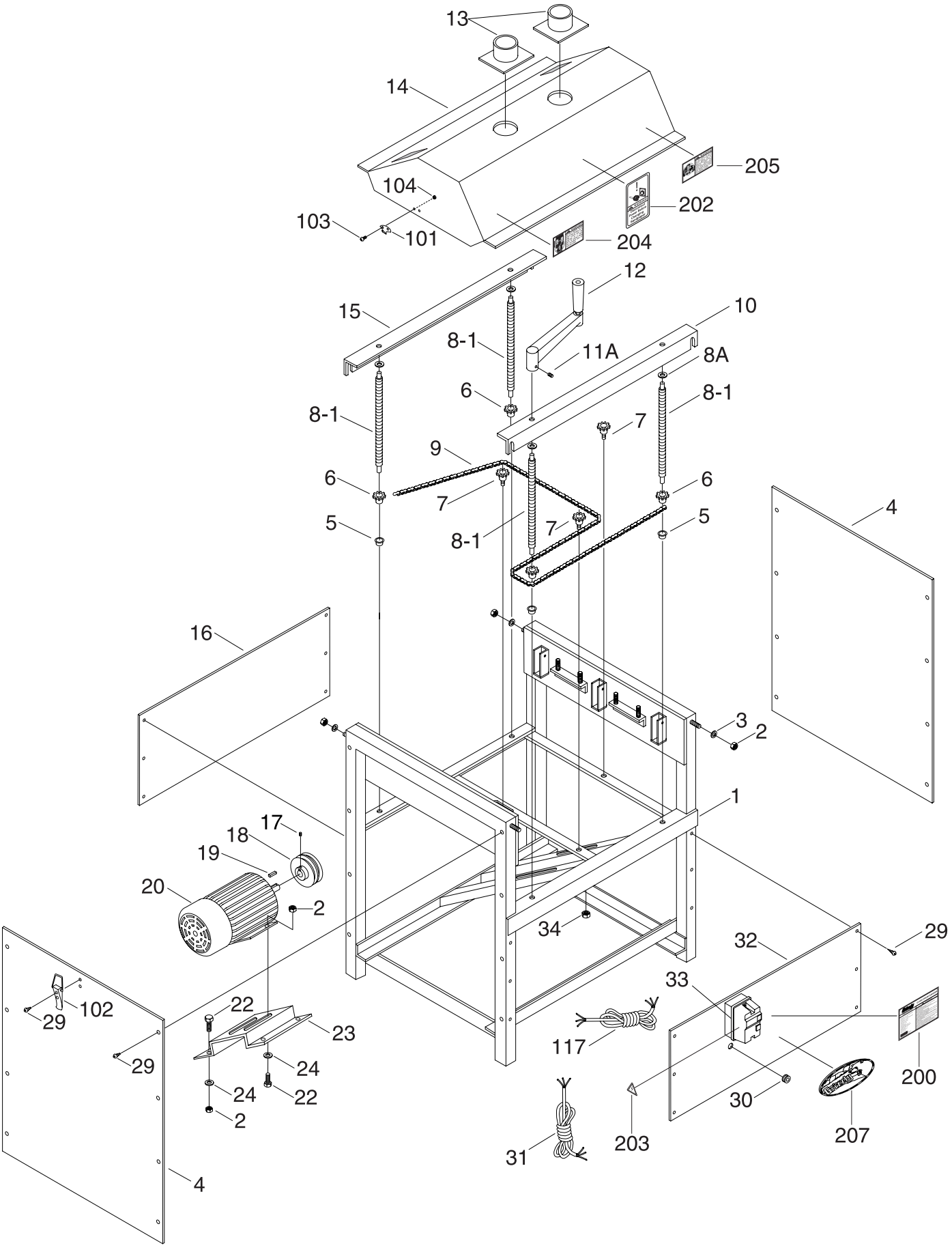
Conveyor Motor:
- Type.....Start Induction
- Horsepower .....¼ HP
- Voltage 220V
- Amps.....3
- RPM 1725
- Phase / Cycle .....Single / 60 HZ
- Power Transfer .....Chain Drive

General Construction:
- Cabinet .....Steel
- Sanding Drums (2) .....Aluminum
- Pressure Rollers (3) .....Rubber

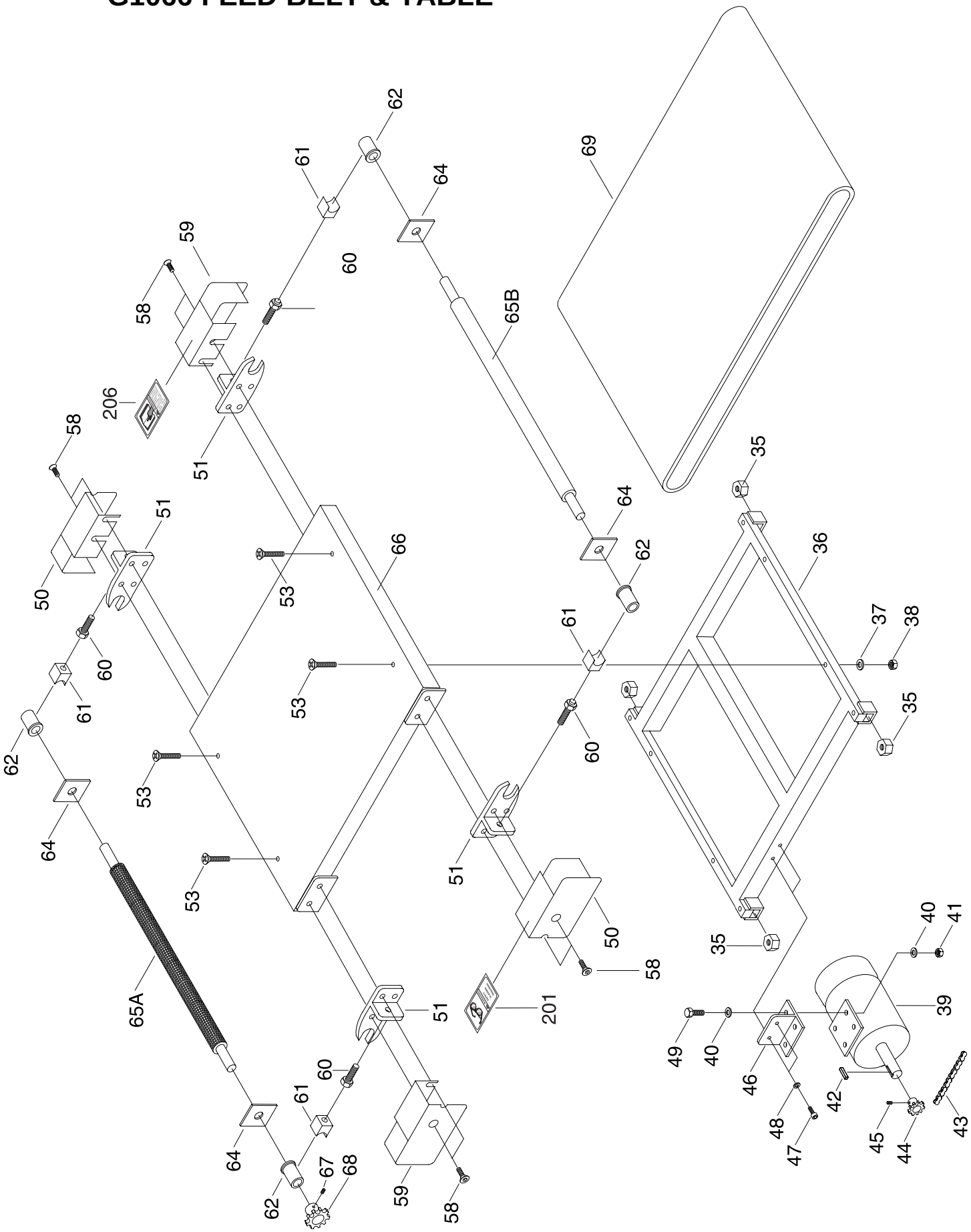
Requires Sanding Rolls 6" Wide

Specifications, while deemed accurate, are not guaranteed.

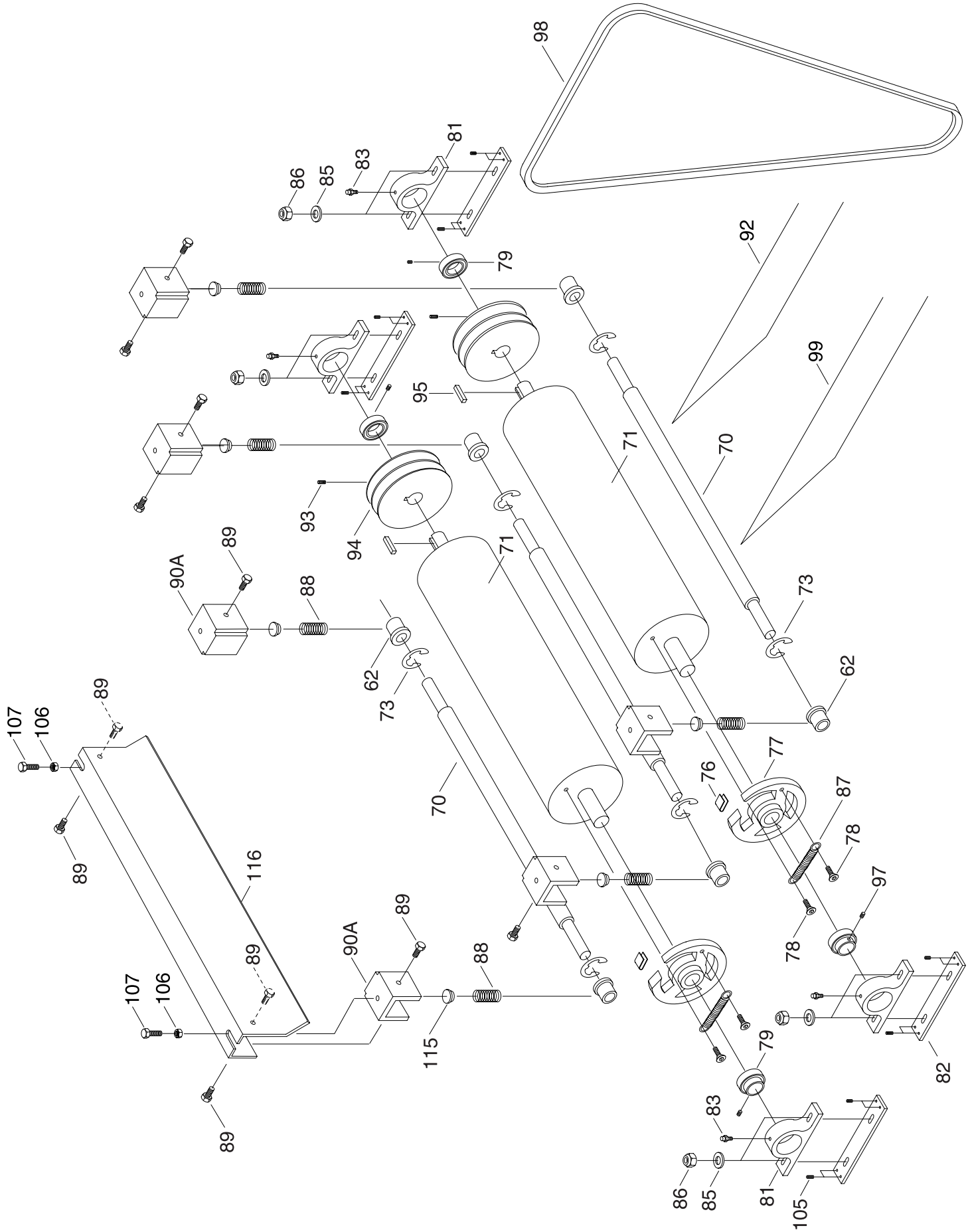
G1066 STAND & TABLE ELEVATION



G1066 FEED BELT & TABLE



G1066 DRUM & ROLLER MECHANISM



G1066 PARTS LIST

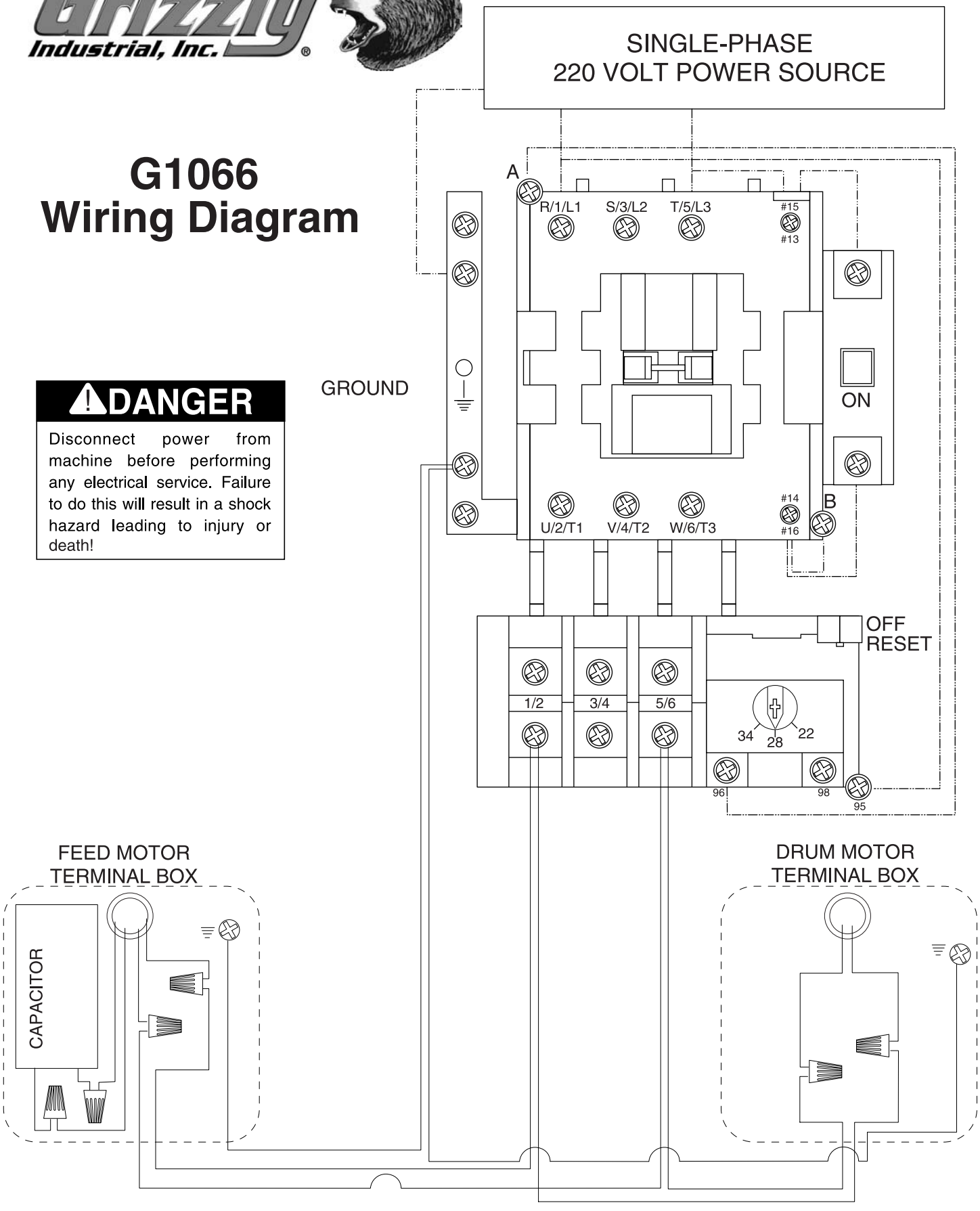
REF	PART #	DESCRIPTION
01	P1066001	FRAME
02	PN08	HEX NUT 3/8"-16
03	PW02	WASHER 3/8"
04	P1066004	SIDE PANEL
05	P1066005	BUSHING
06	P1066006	SPROCKET
07	P1066007	SPROCKET
08-1	P1066008-1	TABLE LEAD SCREW
08A	P1066008A	SHIM
09	P1066009	ELEVATION CHAIN
10	P1066010	FRONT BRACE
11A	PSS28	SETSCREW 5/16"-24 X 3/8"
12	P1066012	CRANK HANDLE ASSY
13	G1838	DUST PORT
14	P1066014	HOOD
15	P1066015	REAR BRACE
16	P1066016	REAR PANEL
17	PSS07	SETSCREW 1/4"-20 x 1/2"
18	P1066018	MOTOR PULLEY
19	PK02	KEY 1/4" x 1/4" x 3"
20	P1066020	5 HP MOTOR
22	PB21	HEX BOLT 3/8"-16 x 3/4"
23	P1066023	BRACKET
24	PW02	FLAT WASHER 3/8"
29	PHTEK1	SELF TAPPING SCREW
30	P1066030	GROMMET
31	PWRCRD220L	POWER CORD
32	P1066032	FRONT PANEL
33	G4668	SWITCH
34	PN02	HEX NUT 5/16"-18
35A	PN03	HEX NUT 3/16"-16
36	P1066036	TABLE FRAME
37	PW07	FLAT WASHER 5/16"
38	PLN02	LOCK NUT 1/4"-20
39	P1066039	FEED BELT MOTOR
40	PW07	FLAT WASHER 5/16"
41	PN02	NUT 5/16"-18
42	PK34M	KEY 5 x 5 x 20mm
43	P1066043	DRIVE CHAIN
44	P1066044	SPROCKET
45	PSS07	SETSCREW 1/4"-20 x 1/2"
46	P1066046	MOTOR BRACKET
47	PSB16	CAP SCREW 1/4"-20 x 3/4"
48	PW07	FLAT WASHER 5/16"
49	PB03	HEX BOLT 5/16"-18 x 1"
50	P1066050	LEFT ROLLER END GUARD
51	P1066051	ROLLER BRACKET
53	PFH11	FLT HD SCREW 1/4"-20 x 2 3/4"
58	P1066058	SPECIAL BOLT 1/4" - 20 x 5/8"
59	P1066059	RIGHT GUARD
60	P1066060	SPECIAL BOLT

REF	PART #	DESCRIPTION
61	P1066061	BUSHING SUPPORT
62	P1066062	BUSHING
64	P1066064	PLATE
65A	P1066065A	DRIVE ROLLER
65B	P1066065B	IDLE ROLLER
66	P1066066	TABLE
67	PSS07	SETSCREW 1/4"-20 x 1/2"
68	P1066068	SPROCKET
69	P1066069	CONVEYOR BELT
70	P1066070	PRESSURE ROLLER
71	P1066071	SANDING DRUM
73	PR08M	SNAP RING 19mm
76	P1066076	CLIP
77	P1066077	TENSION WHEEL
78	PFH17	FLT HD ALLEN® SCRW 1/4"-20 x 1/2"
79	P1066079	BEARING
81	P1066081	BEARING BLOCK
82	P1066082	BRG BLOCK PLATE TAPPD
83	P1066083	GREASE FITTING
85	PW02	WASHER 3/8"
86	PLN01	LOCK NUT 3/8"-16
87	P1066087	TENSION SPRING
88	P1066088	COMPRESSION SPRING
89	PB05M	HEX BOLT M6 - 1.0 x 8
90A	P1066090A	BRACKET
92	G2787 - G2789	SANDING PAPER ROLLS
93	PSS07	SETSCREW 1/4"-20 x 1/2"
94	P1066094	DRUM PULLEY
95	PK42M	KEY 6 x 6 x 30
97	PSS03M	SETSCREW M6 - 1.0 x 8
98	PVB67	V BELT B-67
99	P1066099	FELT FOR SANDING DRUM
101	P1073099	STRIKE
102	P1073098	LATCH
103	PS23	PHLP HD SCREW 8-32 x 1/4"
104	PN14	HEX NUT 8 - 32
105	P1066105	SPECIAL SETSCREW
106	PN05	HEX NUT 1/4"-20
107	PB19	HEX BOLT 1/4"-20 x 1/2"
115	P1066115	SPRING PLATE
116	P1066116	DUST SCOOP-DEFLECTOR
117	PWRCRD220S	POWER CORD
200	P1066200	G1066 ID/WARNING LABEL
201	PLABEL-11	SAFETY GLASSES LABEL
202	PLABEL-13	UPLUG SANDER LABEL
203	PLABEL-14	ELECTRICITY LABEL
204	PLABEL-17	FEED ONE PIECE LABEL
205	PLABEL-16	DONT STAND BEHIND LABEL
206	PLABEL-12	READ MANUAL LABEL
207	G8589	LARGE GRIZZLY LOGO

G1066
Wiring Diagram

⚠DANGER

Disconnect power from machine before performing any electrical service. Failure to do this will result in a shock hazard leading to injury or death!



MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G1066Z
DRUM SANDER W/VARIABLE SPEED CONVEYOR

Design Type .....Floor Model

Overall Dimensions:
- Height .....44½"
- Width .....50"
- Depth .....37"
- Table Height .....33''
- Shipping Weight .....430 lbs.
- Net Weight .....389 lbs.
- Crate Size .....39½" L x 41" W x 44" H
- Base Footprint .....34½" x 24"

Capacities:
- Maximum Board Width .....23½"
- Maximum Board Thickness .....4¼"
- Minimum Board Length ..... 9"
- Minimum Board Thickness .....⅛"
- Surface Speed of Drums .....2300 FPM
- Conveyor Feed Rate .....Variable, 0-20 FPM

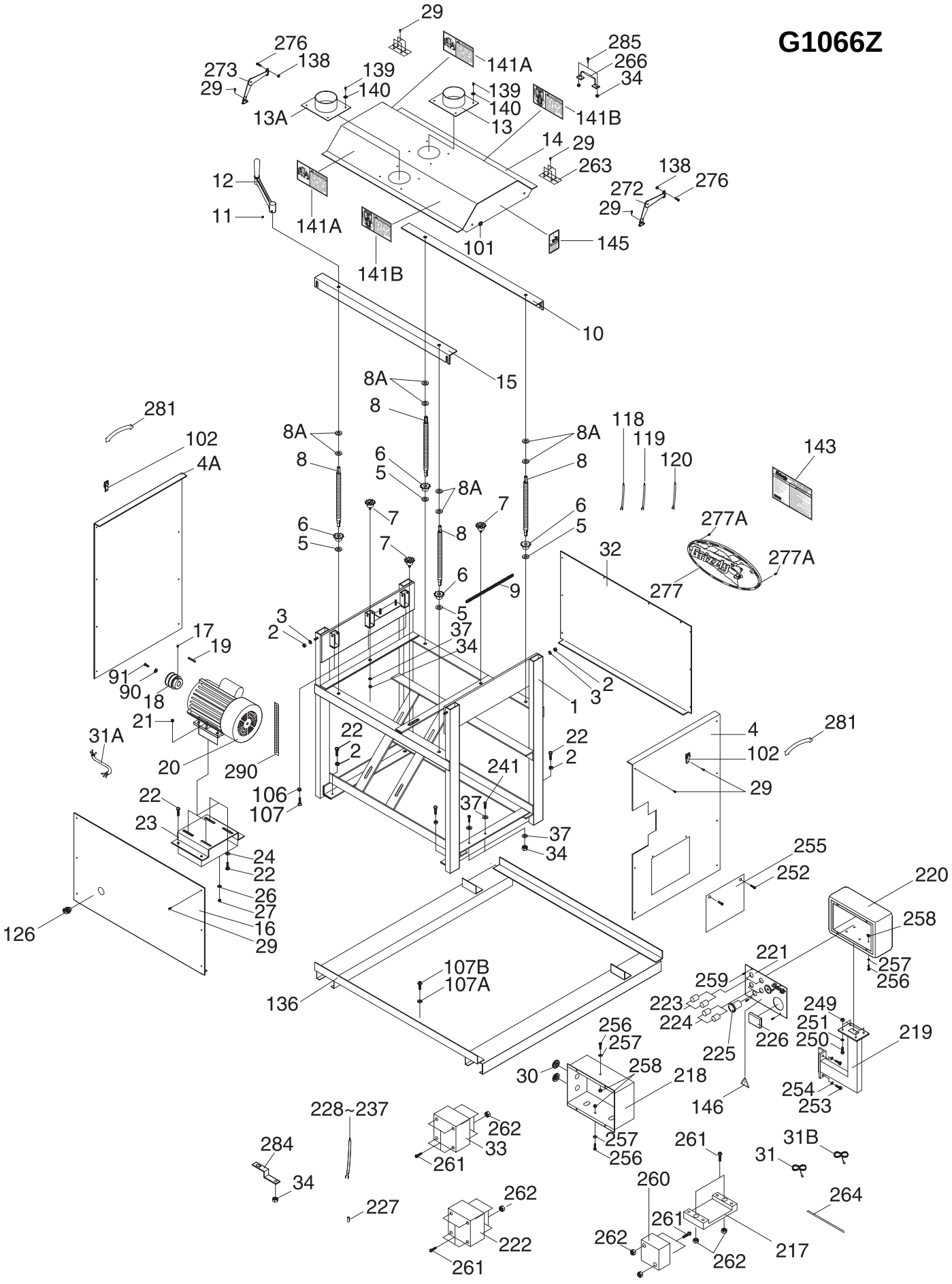
Sanding Drum Motor:
- Type .....TEFC Capacitor Start Induction
- Horsepower.....5 HP
- Voltage .....220V ONLY
- Amps.....25
- Motor Speed .....3450 RPM
- Phase / Cycle .....Single / 60 HZ
- Power Transfer ..... Dual Belt Drive

Conveyor Motor:
- Type .....Universal Variable Speed
- Horsepower .....¼ HP
- Voltage 220V
- Amps.....3
- Motor Speed .....0-60 RPM
- Phase / Cycle .....Single / 60 HZ
- Power Transfer .....Chain Drive

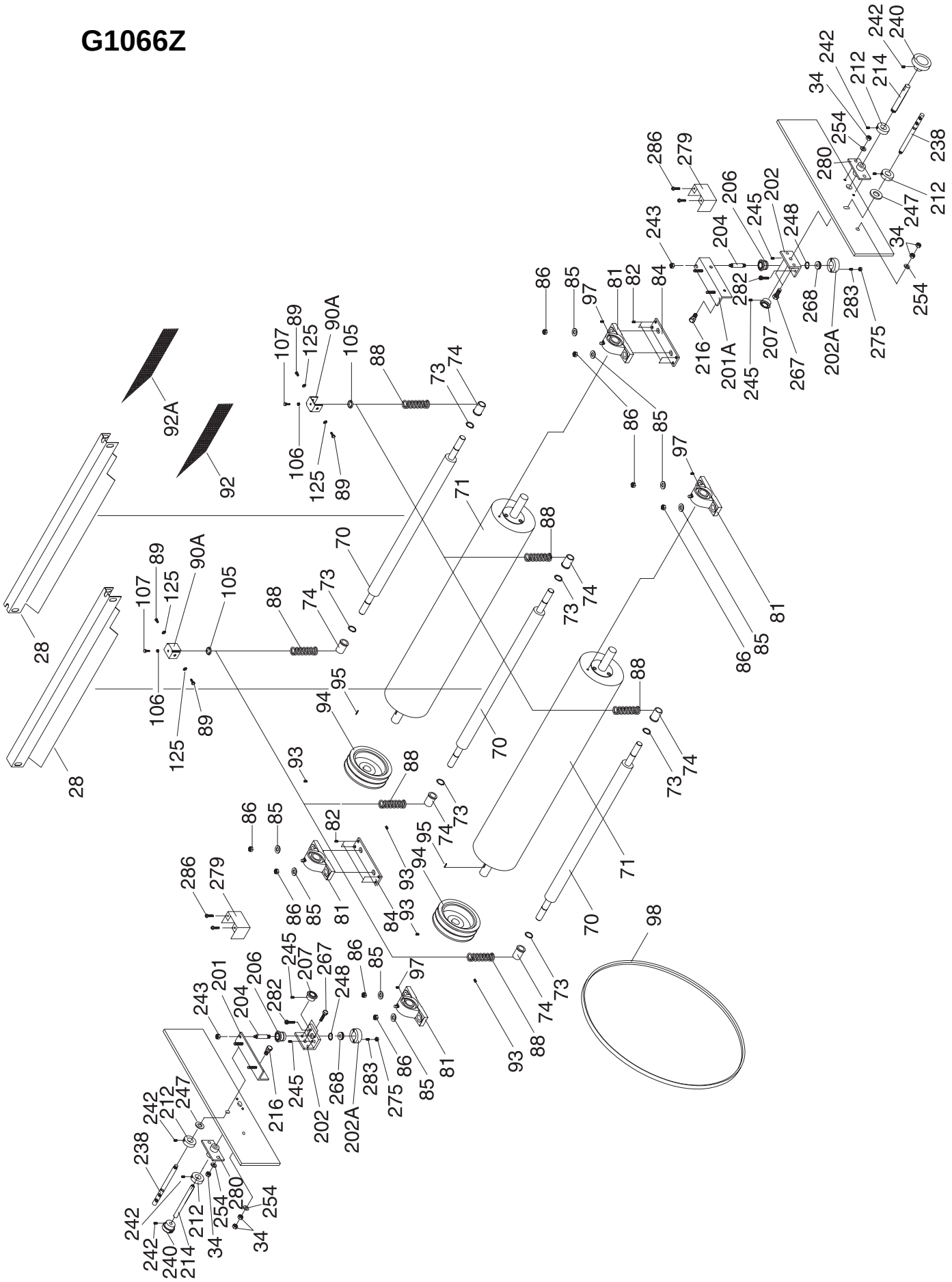
General Construction:
- Frame .....Steel
- Sanding Drums (2) .....6" Diameter Aluminum
- Pressure Rollers (3) .....1 ⅝" Diameter Rubber
- Conveyor Belt .....24'' x 74'' Continuous Industrial Quality Belt
- .....2-4" Dust Ports Included
- .....Easy Access Control Panel w/Load Meter
- .....External Micro-Adjustment On Outfeed Drum
- .....Uses 3" Wide Hook and Loop Sandpaper
- .....Variable Speed Conveyor
- .....Improved Dust Collection

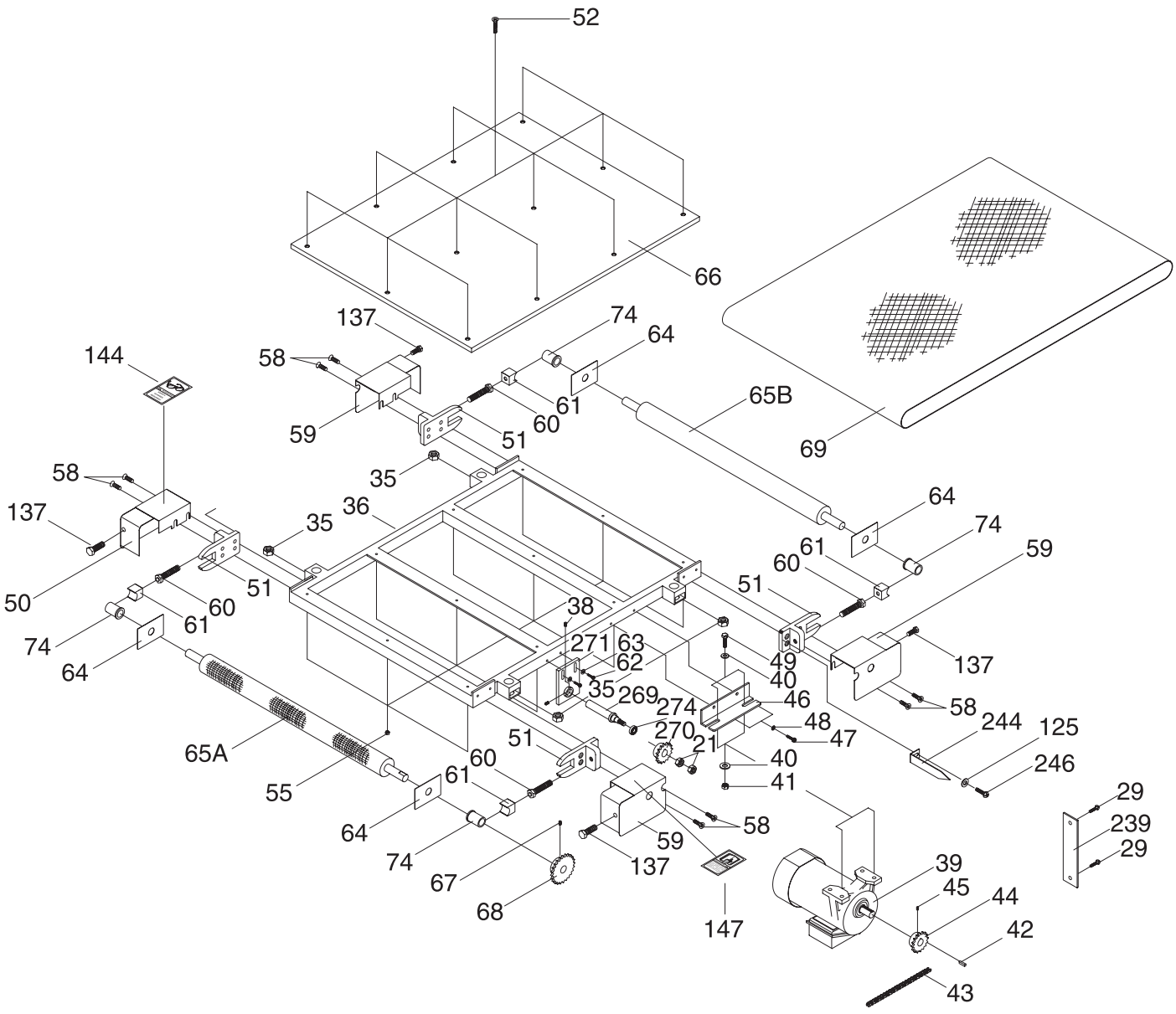
Specifications, while deemed accurate, are not guaranteed.

G1066Z


29
276
138
273
29
139
140
13A
141A
139
140
13
141B
285
266
34
14
29
263
138
276
272
29
12
11
141A
141B
101
145
10
15
8A
8
8A
8
6
5
8A
7
8
7
6
5
7
6
5
9
3
2
37
34
1
3
2
32
277A
277
277A
118
119
120
143
281
102
4A
17
19
91
90
18
21
20
290
31A
22
2
106
107
22
23
24
22
26
27
16
29
126
22
2
241
37
37
34
4
281
102
29
255
252
220
258
257
256
221
259
223
224
225
226
249
251
250
219
256
257
258
218
30
146
254
253
228~237
284
34
227
262
33
261
262
222
261
261
31B
31
264
260
261
262
262
217

G1066Z


92A
92
28
107
89
125
90A
105
106
88
73
74
71
70
95
94
93
86
85
82
81
84
97
98
286
279
243
201
204
206
282
245
207
267
248
202
202A
268
283
275
216
201A
247
212
214
240
242
238
254
280
34


52
66
137
74
64
144
58
61
65B
59
60
51
69
35
58
64
137
36
74
35
61
59
60
51
51
38
271
63
137
62
49
40
35
269
46
58
274
48
244
125
65A
270
47
51
21
246
60
40
61
41
55
29
58
64
239
59
74
137
39
29
67
45
44
68
147
42
43

REF	PART #	DESCRIPTION
1	P1066001	FRAME
2	PN08	HEX NUT 3/8"-16
3	PW02	FLAT WASHER 3/8"
4	P1066Z004	SIDE PANEL
4A	P1066Z004A	SIDE PANEL
5	PW01	FLAT WASHER 1/2"
6	P1066006	SPROCKET
7	P1066007	SPROCKET W/SHAFT
8	P1066008	TABLE LEAD SCREW
8A	PW01	FLAT WASHER 1/2"
9	P1066009	ELEVATION CHAIN
10	P1066010	FRONT BRACE
11	PSS02	SETSCREW 5/16"-18 x 3/8"
12	P1066012	HANDLE
13	P1066013	DUST PORT
13A	P1066Z013A	DUST PORT
14	P1066Z014	HOOD
15	P1066015	REAR BRACE
16	P1066Z016	REAR PANEL
17	PSS07	SETSCREW 1/4"-20 x 1/2"
18	P1066018	MOTOR PULLEY
19	PK23M	KEY 5 x 5 x 25
20	P1066Z020	5 HP MOTOR
21	PN08	HEX NUT 3/8"-16
22	PB18	HEX BOLT 3/8"-16 x 1"
23	P1066023	BRACKET
24	PW02	FLAT WASHER 3/8"
26	PW02	FLAT WASHER 3/8"
27	PN08	HEX NUT 3/8"-16
28	P1066Z028	DUST DEFLECTOR
29	PHTEK7	SELF TAP SCREW #8 x 3/8"
30	P1066Z030	GROMMET 28
31	PWRCRD220L	POWER CORD
31A	PWRCRD220S	MOTOR CORD
31B	PWRCRD220S	MOTOR CORD
32	P1066032	***USE P1066032***
33	P1066Z033	SWITCH 5 HP
34	PN02	HEX NUT 5/16"-18
35	PN03	HEX NUT 3/4"-16
36	P1066036	TABLE FRAME
37	PW07	FLAT WASHER 5/16"
38	PSS33	SETSCREW 3/8"-18 x 1/4"
39	P1066Z039	FEED BELT MOTOR
40	PW07	FLAT WASHER 5/16"
41	PN02	HEX NUT 5/16"-18
42	PK34M	KEY 5 x 5 x 20
43	P1066043	DRIVE CHAIN
44	P1066044	SPROCKET
45	PSS11	SETSCREW 1/4"-20 x 1/4"
46	P1066046	MOTOR BRACKET
47	PSB05	CAP SCREW 1/4"-20 x 3/4"
48	PW06	FLAT WASHER 1/4"

REF	PART #	DESCRIPTION
49	PSB12	HEX BOLT 5/16"-18 x 1 1/4"
50	P1066050	LEFT ROLLER END GUARD
51	P1066051	ROLLER BRACKET
52	PFH12	FLT HD SCREW 1/4"-20 X 1"
55	PLN02	LOCK NUT 1/4"-20
58	PSB05	CAP SCREW 1/4"-20 X 3/4"
59	P1066059	RIGHT ROLLER END GUARD
60	P1066060	SPECIAL BOLT 1/2"-20 X 2 1/2"
61	P1066061	BUSHING SUPPORT
62	PB57	HEX BOLT 1/4"-20 X 1/4"
63	PW06	FLAT WASHER 1/4"
64	P1066064	PLATE
65A	P1066065A	DRIVE ROLLER
65B	P1066065B	IDLER ROLLER
66	P1066066	TABLE
67	PSS08	SETSCREW 5/16"-18 x 1/2"
68	P1066068	SPROCKET
69	P1066Z069	CONVEYOR BELT
70	P1066070	PRESSURE ROLLER
71	P1066Z071	SANDING DRUM
73	PR08M	EXT RETAIN RING 19MM
74	P1066062	BUSHING
81	P1066081	BEARING BLOCK
82	PSS08	SETSCREW 5/16"-24 x 1/2"
84	P1066082	ADJUST PLATE
85	PW02	FLAT WASHER 3/8"
86	PLN01	LOCK NUT 3/8"-16
88	P1066088	COMPRESSION SPRING
89	PB51	HEX BOLT 1/4"-20 x 3/8"
90	PW02	FLAT WASHER 3/8"
90A	P1066090A	BRACKET
91	PB19M	HEX BOLT M8-1.25 x 24
92	P1066Z092	HOOK & LOOP SANDBELT
92A	P1066Z092A	HOOK & LOOP DRUM CVR
93	PSS09	SETSCREW 3/8"-16 x 1/2"
94	P1066094	DRUM PULLEY
95	PK10	KEY 1/4" x 1/4" x 1 1/4"
97	PSS02M	SETSCREW M6-1.0 x 6
98	PVB67	V BELT B-67
101	P1073099	STRIKE
102	P1073098	LATCH
105	P1066115	SPRING GUIDE
106	PN05	HEX NUT 1/4"-20
107	PB02	HEX BOLT 1/4"-20 x 5/8"
107A	PW06	FLAT WASHER 1/4"
107B	PHTEK9	HEX TAP SCR 1/4"-14 X 1 1/2"
118	P1066Z118	LINE CORD
119	P1066Z119	LINE CORD
120	P1066Z120	EARTH LEAD (GREEN)
125	PW06	FLAT WASHER 1/4"
126	PSW10	STRAIN RELIEF 3/4"
136	P1066Z136	BASE STEEL CRATE

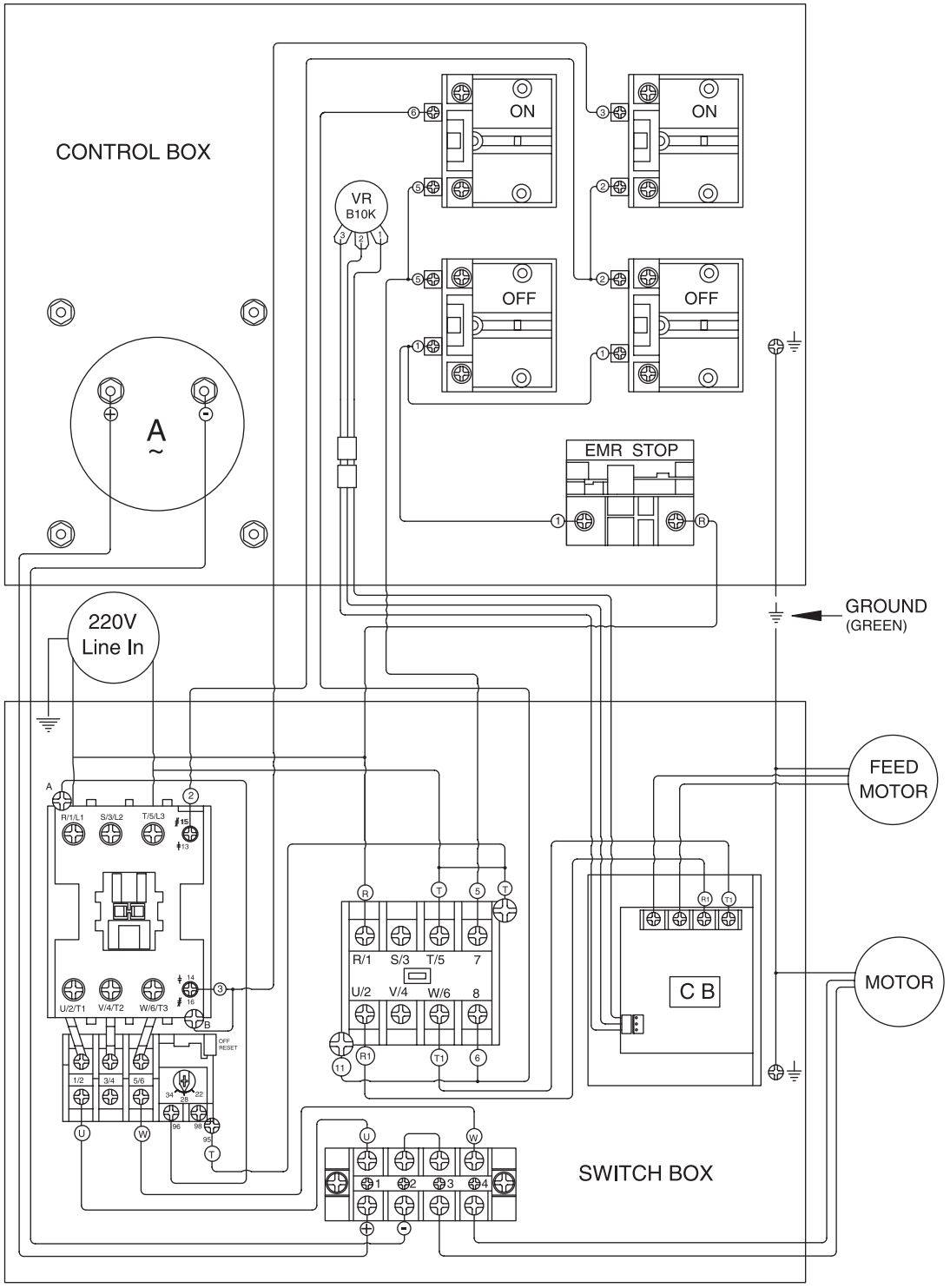
REF	PART #	DESCRIPTION
137	PS06	PHLP HD SCR 10-24 X 3/8"
138	PN04M	HEX NUT M4-0.7
139	PHTEK8	SELF TAP SCR #8 X 1/2"
140	PW03	FLAT WASHER #10
141A	PLABEL-22	HAND PINCH IN BELT LABEL
141B	PLABEL-17	FEED ONLY ONE PIECE LABEL
143	P1066Z143	MACHINE ID/WARNING
144	PLABEL-11	SAFETY GLASSES LABEL
145	PLABEL-13	UNPLUG SANDER LABEL
146	PLABEL-14	ELECTRICITY LABEL
147	PLABEL-22	HAND PINCH IN BELT LABEL
201	P1066Z201	LEFT BEARING SEAT
201A	P1066Z201A	RIGHT BEARING SEAT
202	P1066Z202	MOUNTING BRACKET
202A	P1066Z202A	THRUST BEARING SEAT
204	P1066Z204	MICRO ADJUST SCREW
206	P1066Z206	BEVEL GEAR A
207	P1066Z207	BEVEL GEAR B
212	P1066Z212	LOCK COLLAR
214	P1066Z214	DRIVE SHAFT
216	P1066Z216	SPECIAL BOLT 5/16"-18 X 1/2"
217	P1066Z217	WIRING PANEL
218	P1066Z218	MAGNETIC SWITCH BOX
219	P1066Z219	PEDESTAL ARM
220	P1066Z220	CONTROL BOX
221	P1066Z221	CONTROL PANEL
222	P1066Z222	MAGNETIC SWITCH
223	P1066Z223	ON SWITCH
224	P1066Z224	OFF SWITCH
225	P1066Z225	EMGCY STOP SWITCH
226	P1066Z226	LOAD/AMP METER
227	P1066Z227	CABLE MARKER
228	P1066Z228	CONTROL WIRE
229	P1066Z229	CONTROL WIRE
230	P1066Z230	CONTROL WIRE
231	P1066Z231	CONTROL WIRE
232	P1066Z232	CONTROL WIRE
233	P1066Z233	CONTROL WIRE
234	P1066Z234	CONTROL WIRE
235	P1066Z235	CONTROL WIRE
236	P1066Z236	CONTROL WIRE
237	P1066Z237	CONTROL WIRE
238	P1066Z238	LOCK HANDLE
239	P1066Z239	SCALE
240	P1066Z240	CONTROL KNOB
241	PB03	HEX BOLT 5/16"-18 x 1"

REF	PART #	DESCRIPTION
242	PSS04	SETSCREW 1/4"-20 x 5/16"
243	PLN02	LOCK NUT 1/4"-20
244	P1066Z244	POINTER
245	PSS29	SETSCREW 3/16"-24 x 1/4"
246	PS07	PHLP HD SCR 1/4"-20 x 3/8"
247	PW07	FLAT WASHER 5/16"
248	PR09M	EXT RETAIN RING 20MM
249	PN05	HEX NUT 1/4"-20
250	PB05	HEX BOLT 1/4"-20 x 3/4"
251	PW06	FLAT WASHER 1/4"
252	PS06	PHLP HD SCR 10-24 x 3/8"
253	PB03	HEX BOLT 5/16"-18 x 1"
254	PW07	FLAT WASHER 5/16"
255	P1066Z255	DOOR
256	PS01	PHLP HD SCR 10-24 x 1/2"
257	PW03	FLAT WASHER #10
258	PN07	HEX NUT 10-24
259	PHTEK6	SELF TAP SCR #10 x 3/8"
260	P1066Z260	VARIABLE SPEED CIRCUIT BOARD
261	PS22	PHLP HD SCR 3/16"-4 x 5/8"
262	PN07	HEX NUT 10-24
263	P1066Z263	HINGE
264	P1066Z264	NYLON CABLE TIES
266	P1066Z266	HANDLE
267	PSB11	CAP SCR 5/16"-18 x 1 1/4"
268	P51101	THRUST BEARING 51101
269	P1066Z269	SPROCKET SHAFT
270	P1066Z270	SPROCKET
271	P1066Z271	ADJUSTMENT PLATE
272	P1066Z272	LEFT SUPPORT ARM
273	P1066Z273	RIGHT SUPPORT ARM
274	P6201	BEARING 6201-2RS
275	PN11	HEX NUT 3/8"-24
276	PS17M	PHLP HD SCR M4-0.7 x 6
277	G8589	GRIZZLY LOGO, LARGE
277A	PHTEK10	TAP SCREW #4 X 3/8"
278	P1066Z278	SELF ADHESIVE FOAM
279	P1066Z279	DUST COVER
280	P1066Z280	DRIVE SHAFT BRACKET
281	P1066Z281	DIRECTION LABEL
282	PSB01	CAP SCREW 1/4"-20 x 5/8"
283	PSS34	SETSCREW 10"-24 x 1/2"
284	P1066Z284	FIXING PLATE
285	PSB07	CAP SCREW 5/16"-18 x 3/4"
286	PHTEK6	SELF TAP SCR #10 x 3/8"
290	P1066Z290	TABLE HEIGHT SCALE

G1066Z Wiring Diagram

DANGER

Disconnect power from machine before performing any electrical service. Failure to do this will result in a shock hazard leading to injury or death!



MACHINE DATA SHEET

Customer Service #: (570) 326-3806 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G1079 16" DRUM SANDER

Design Type .....Floor Model

Overall Dimensions:
- Width .....27"
- Height .....42½"
- Depth .....36½"
- Weight (Shipping).....285 lbs.
- Weight (In Place) .....276 lbs.
- Box #1 Size.....40½" L x 30" W x 34" H
- Box #2 Size .....11" L x 8" W x 6" H
- Footprint .....29" x 32"

Capacities:
- Maximum Board Width .....16"
- Maximum Board Thickness .....3½"
- Minimum Board Length .....9"
- Minimum Board Thickness .....⅛"
- Diameter of Drum .....6"
- Surface Speed of Drums .....2100 FPM
- Conveyor Speed .....11 FPM

Sanding Drum Motor:
- Type .....TEFC Capacitor Start Induction
- Horsepower .....1½ HP
- Voltage .....220V ONLY
- Amps.....8
- RPM 3450
- Phase / Cycle.....Single / 60 HZ
- Power Transfer .....Belt Drive

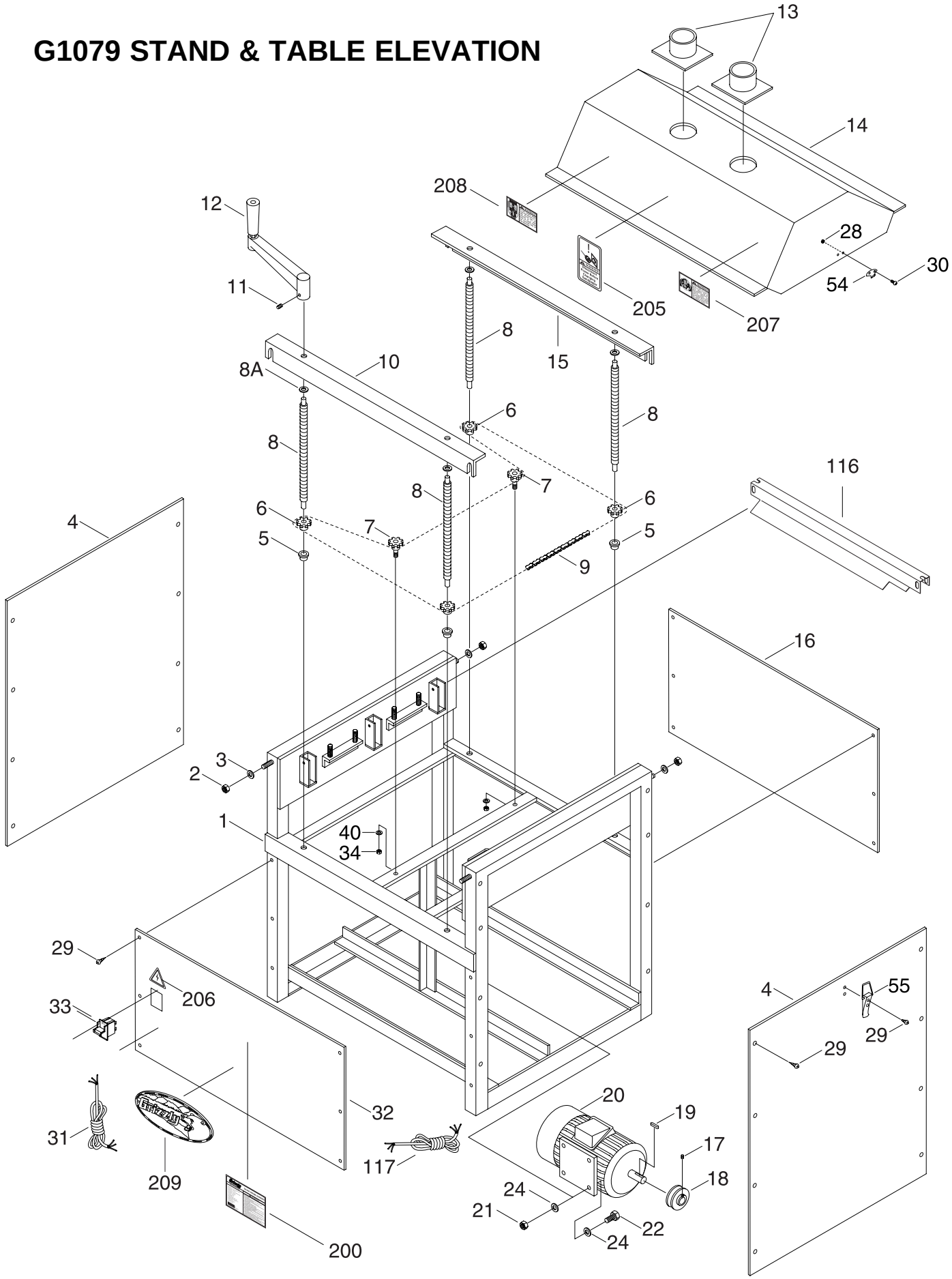
Conveyor Feed Motor:
- Type .....TEFC Capacitor Start Induction
- Horsepower .....¼ HP
- Voltage 220V
- Amps.....3
- RPM 1725
- Phase .....Single / 60 Hz
- Power Transfer .....Chain Drive

General Construction:
- Cabinet .....Steel
- Sanding Drums (2) .....Aluminum
- Pressure Rollers (3) .....Rubber

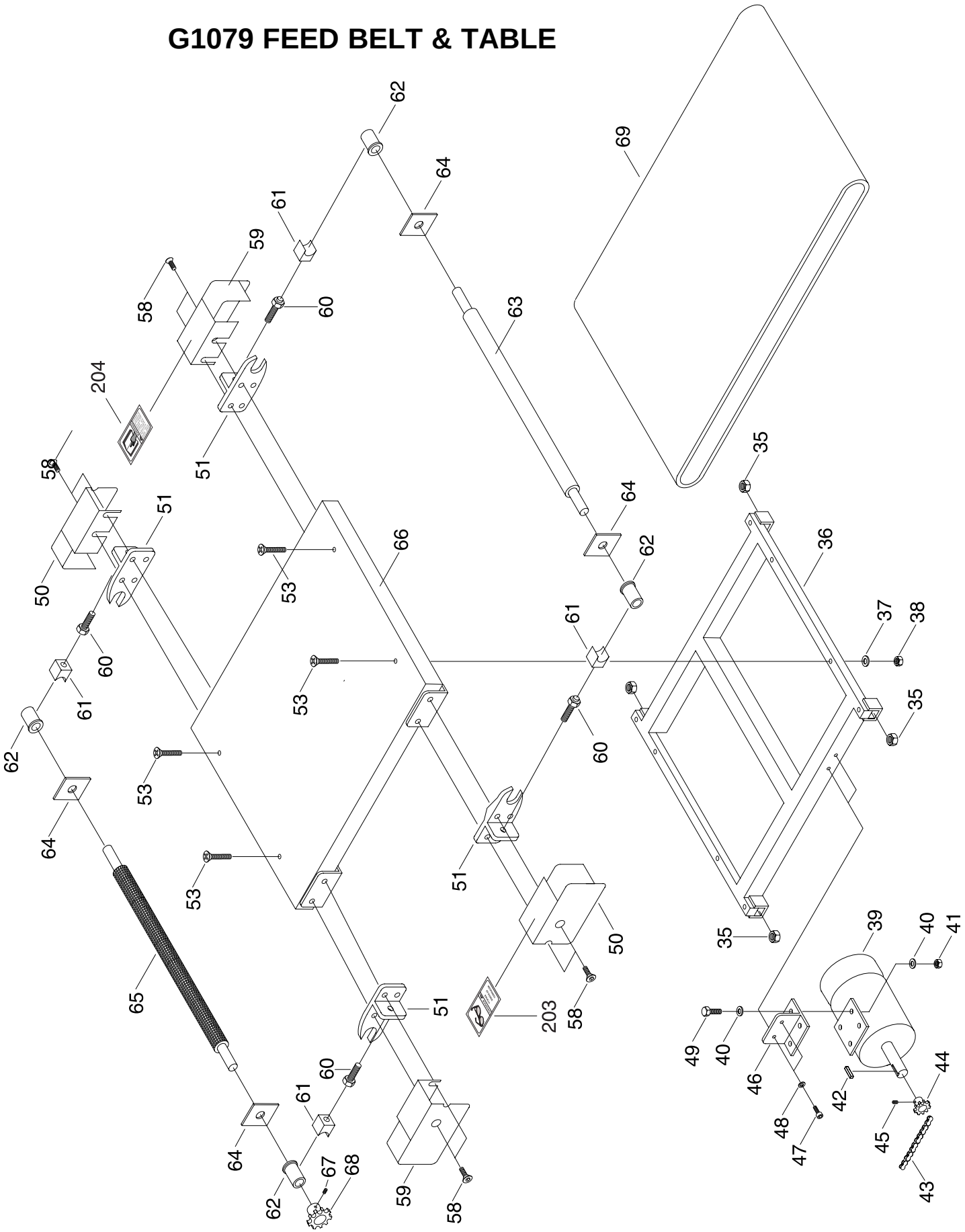
Requires Sanding Rolls 6" Wide

Specifications, while deemed accurate, are not guaranteed.

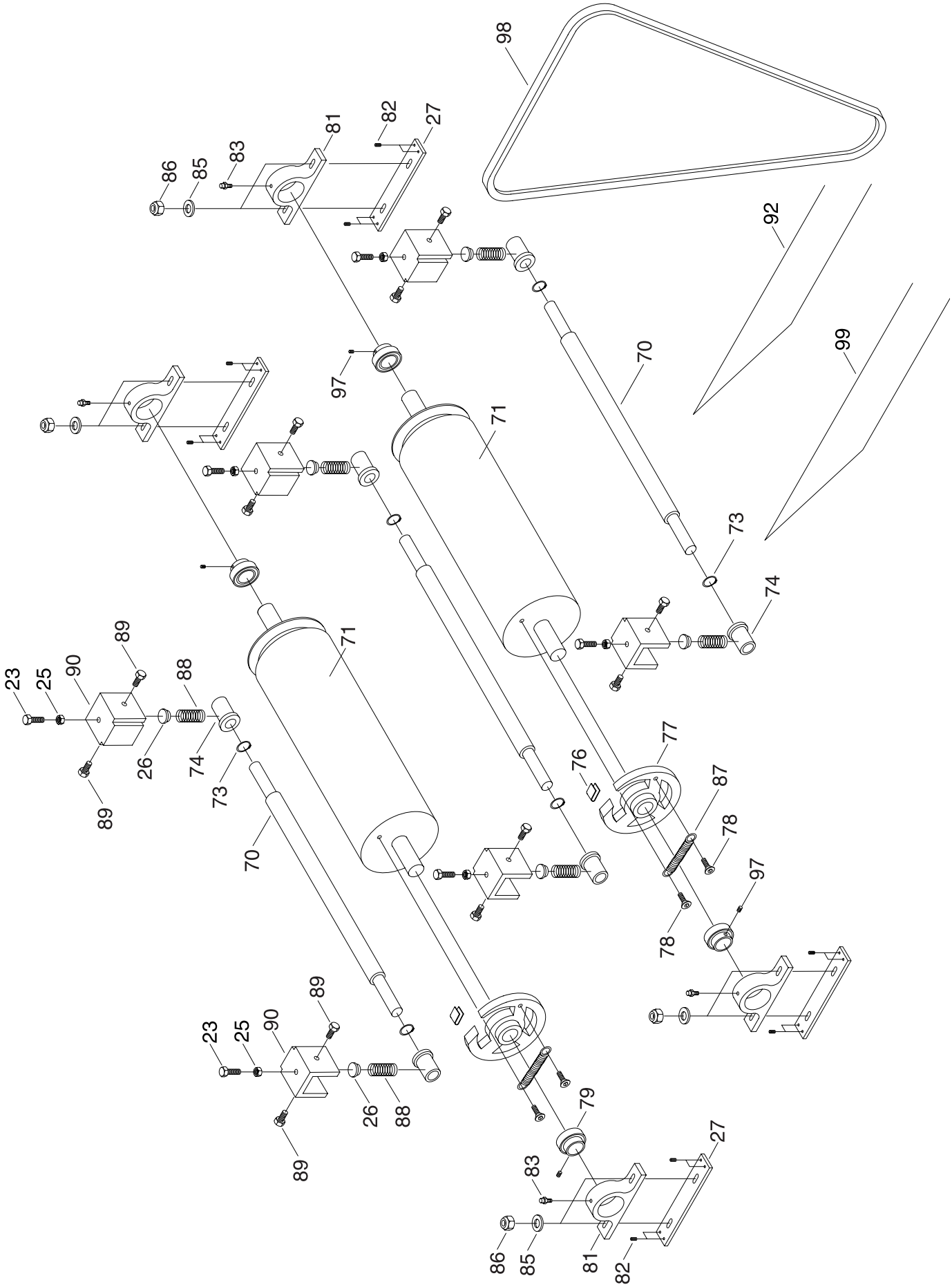
G1079 STAND & TABLE ELEVATION



G1079 FEED BELT & TABLE



G1079 DRUM & ROLLER MECHANISM

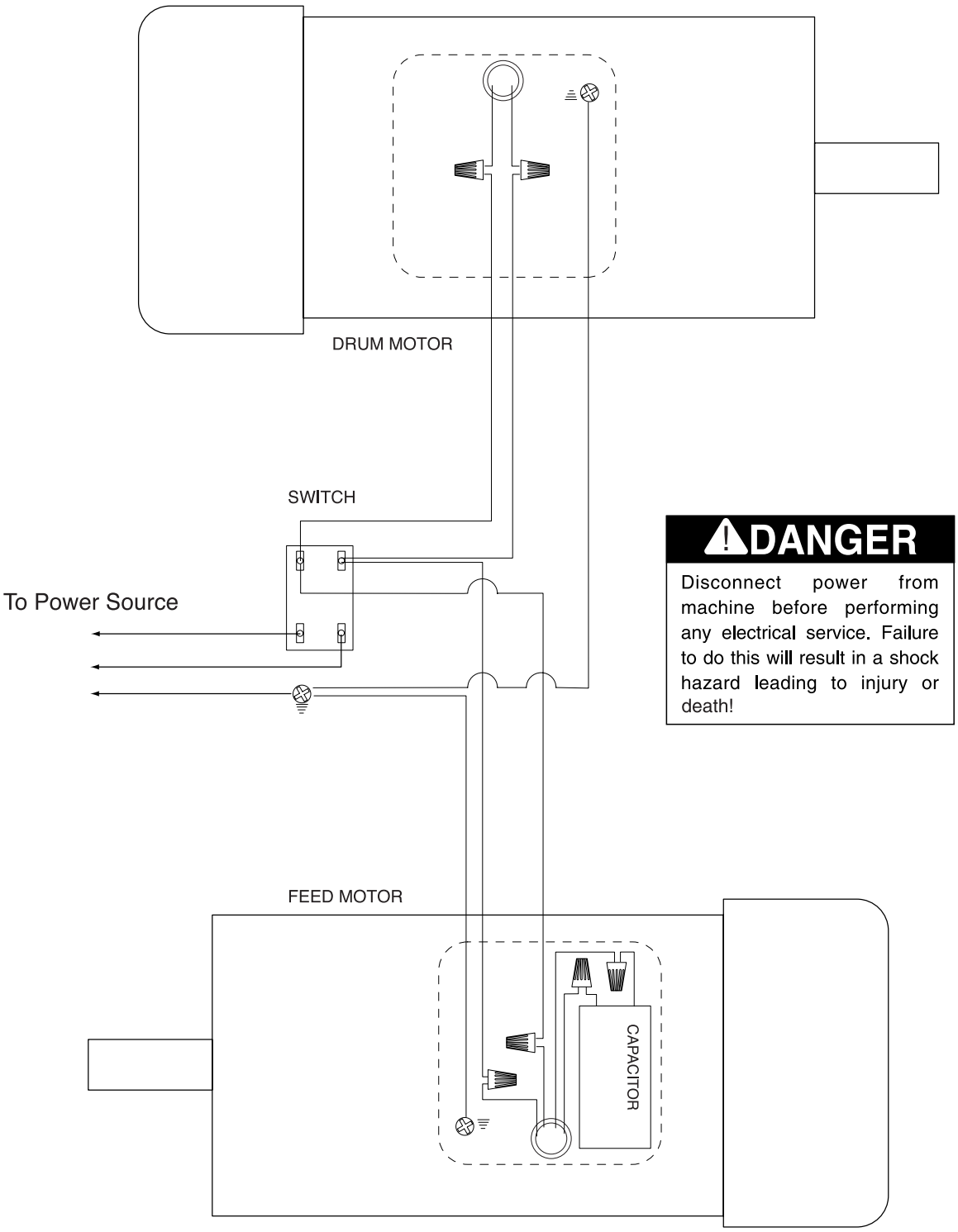


G1079 PARTS LIST

REF	PART #	DESCRIPTION
01	P1079001	FRAME
02	PN08	HEX NUT 3/8"-16
03	PW02	WASHER 3/8"
04	P1079004	SIDE PANEL
05	P1066005	BUSHING
06	P1066006	SPROCKET
07	P1066007	SPROCKET W/SHAFT
08	P1079008	TABLE SCREW
08A	P1066008A	SHIM
09	P1079009	ELEVATION CHAIN
10	P1079010	FRONT BRACE
11	PSS28	SETSCREW 5/16"-24 x 3/8"
12	P1066012	CRANK HANDLE
13	G1838	DUST PORT
14	P1079014	HOOD
15	P1079015	REAR BRACE
16	P1079016	REAR PANEL
17	PSS08	SETSCREW 1/4"-20 x 1/2"
18	P1079018	MOTOR PULLEY
19	PK12M	KEY 5 x 5 x 30mm
20	P1079020	1 1/2 HP MOTOR
21	PN08	HEX NUT 3/8"-16
22	PB21	HEX BOLT 3/8"-16 x 3/4"
23	PB05	HEX BOLT 1/4"-20 x 3/4"
24	PW02	FLAT WASHER 3/8"
25	PN05	HEX NUT 1/4"-20
26	P1066115	SPRING PLATE
27	P1079027	ADJUST PLATE
28	PN14	HEX NUT 8-32
29	PHTEK1	SELF TAPPING SCREW
30	PS24	PHLP HD SCREW 8-32 x 3/8"
31	PWRCRD220L	POWER CORD
32	P1079032	FRONT PANEL
33	PSW06	SWITCH
34	PN02	NUT 5/16"-18
35	P1079035	HEX NUT
36	P1079036	TABLE FRAME
37	PW07	FLAT WASHER 5/16"
38	PLN02	LOCK NUT 1/4"-20
39	P1066039	FEED BELT MOTOR
40	PW07	FLAT WASHER 5/16"
41	PN02	HEX NUT 5/16"-18
42	PK34M	KEY 5 x 5 x 20mm
43	P1079043	DRIVE CHAIN
44	P1066044	SPROCKET
45	PSS07	SETSCREW 1/4"-20 x 1/2"
46	P1066046	MOTOR BRACKET
47	PSB05	CAP SCREW 1/4"-20 x 3/4"
48	PW06	FLAT WASHER 1/4"

REF	PART #	DESCRIPTION
49	PB03	HEX BOLT 5/16"-18 x 1"
50	P1066050	LEFT ROLLER END GUARD
51	P1066051	ROLLER BRACKET
53	PFH11	FLT HD SCREW 1/4"-20 x 2 3/4"
54	P1073099	STRIKE
55	P1073098	LATCH
58	P1066058	CAP SCREW 1/4"-20 X 5/8"
59	P1066059	RIGHT ROLLER END GUARD
60	P1066060	SPECIAL BOLT
61	P1066061	BUSHING SUPPORT
62	P1066062	BUSHING
63	P1079063	IDLER ROLLER
64	P1066064	PLATE
65	P1079065	DRIVE ROLLER
66	P1079066	TABLE
67	PSS07	SETSCREW 1/4"-20 x 1/2"
68	P1066068	SPROCKET
69	P1079069	CONVEYOR BELT
70	P1079070	PRESSURE ROLLER
71	P1079071	SANDING DRUM
73	PR08M	SNAP RING 19mm
74	P1066074	BUSHING
76	P1066076	CLIP
77	P1066077	TENSION WHEEL
78	P1066078	SPECIAL BOLT 1/4"-20 x 5/8"
79	P1079079	BEARING
81	P1079081	BEARING BLOCK
82	PSS28	SETSCREW 5/16"-24 x 3/8"
83	P1066083	GREASE FITTING
85	PW02	FLAT WASHER 3/8"
86	PLN01	LOCK NUT 3/8"-16
87	P1066087	TENSION SPRING
88	P1066088	SPRING
89	PB05M	HEX BOLT M6-1.0 x 8
90	P1079090	BRACKET
92	G2787 - G2789	SANDING PAPER ROLLS
97	PSS03M	SETSCREW M6-1.0 x 8
98	PVB60	V BELT B-60
99	P1066099	FELT FOR SANDING DRUM
116	P1079100	DUST DEFLECTOR
117	PWRCRD220S	MOTOR CORD
200	P1079200	G1079 ID/WARING LABEL
203	PLABEL-10	SAFETY GLASSES LABEL
204	PLABEL-11	READ MANUAL LABEL
205	PLABEL-12	UNPLUG SANDER LABEL
206	PLABEL-13	ELECTRICITY LABEL
207	PLABEL-15	DONT STAND BEHIND LABEL
208	PLABEL-16	FEED ONLY ONE LABEL
209	G8588	SMALL GRIZZLY LOGO

G1079 Wiring Diagram



⚠DANGER

Disconnect power from machine before performing any electrical service. Failure to do this will result in a shock hazard leading to injury or death!

TROUBLESHOOTING GUIDE

PROBLEM	SOLUTION
Sanding Paper Clogs Too Quickly *PAM® cooking spray applied to the sandpaper will reduce clogging and improve the effectiveness of cleaning sticks.*	**1.** Sanding paper grit too fine **2.** Too much material is removed at once **3.** Dirty board surface **4.** Insufficient dust collection **5.** Stock is too oily **6.** Board contains too much moisture **7.** Sandpaper worn out
Sandpaper tearing	**1.** Drums not perpendicular to feed direction **2.** Drums not parallel to conveyor table **3.** Sandpaper edges overlapped **4.** Tape is slipping **5.** Too much material is removed at once
Rounding Occurs on the Edges	**1.** Too much material is removed at once
Uneven Thickness on Right and Left Side of the Board	**1.** Drums are not parallel to conveyor table **2.** Uneven wear of sanding paper
Stock Slips on the Conveyor Belt	**1.** Too much material is removed at once **2.** Too much dust on the conveyor belt surface **3.** Worn conveyor belt
Shiny Spots on Sanded Surface	**1.** Sanding paper too old **2.** Drums too high
Marks on Sanded Surface	**1.** Partial damage to sanding paper **2.** Paper overlapped on edges
Conveyor Belt does not Run Smoothly or Stops Completely	**1.** Conveyor belt tension is incorrect **2.** Belt tracking is incorrect
Consistently noticeable "snipe" (more material removed from the ends of the board than the middle).	**1.** No outfeed support **2.** Pressure roller spring tension incorrect **3.** Drum height incorrect in relation to pressure rollers

⚠WARNING

For your safety, turn switch "off" and disconnect the machine from power source before any troubleshooting. Please refer to the adjustment section to make corrections.

Maintenance Notes

Date	Approximate Hours Of Use	Maintenance Performed

WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number,'' which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

WARRANTY CARD

Name _____

Street _____

City _____ State_____ Zip_____

Phone Number_____ E-Mail_____ FAX_____

MODEL #_____ **Serial#**_____ Order#_____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. Of course, all information is strictly confidential.

1. How did you learn about us?

___Advertisement
___Catalog
___World Wide Web
___Friend
___Card Deck

___Other_____

2. Which of the following magazines do you subscribe to.

___American Woodworker
___Cabinetmaker
___Family Handyman
___Fine Homebuilding
___Fine Woodworking
___Home Handyman
___Journal of Light Construction
___Old House Journal
___Popular Mechanics
___Popular Science
___Popular Woodworking
___Practical Homeowner
___Shop Notes
___Today's Homeowner
___WOOD
___WoodenBoat
___Woodshop News
___Woodsmith
___Woodwork
___Woodworker
___Woodworker's Journal
___Workbench

___Other_____

3. Which of the following woodworking/remodeling shows do you watch?

___Backyard America
___Home Time
___The American Woodworker
___The New Yankee Workshop
___This Old House
___Woodwright's Shop

___Other_____

4. What is your annual household income?

___$20,000-$29,999
___$30,000-$39,999
___$40,000-$49,999
___$50,000-$59,999
___$60,000-$69,999
___$70,000-$79,999
___$80,000-$89,999
___$90,000 +

5. What is your age group?

___20-29
___30-39
___40-49
___50-59
___60-69
___70 +

6. How long have you been a woodworker?

___0 - 2 Years
___2 - 8 Years
___8 - 20 Years
___20+ Years

7. How would you rank your woodworking skills?

___Simple
___Intermediate
___Advanced
___Master Craftsman

8. What stationary woodworking tools do you own? Check all that apply.

___Air Compressor
___Band Saw
___Drill Press
___Drum Sander
___Dust Collector
___Horizontal Boring Machine
___Jointer
___Lathe
___Mortiser
___Panel Saw
___Planer
___Power Feeder
___Radial Arm Saw
___Shaper
___Spindle Sander
___Table Saw
___Vacuum Veneer Press
___Wide Belt Sander

___Other_____

9. How many of your woodworking machines are Grizzly? _____

10. Which benchtop tools do you own? Check all that apply.

___1" x 42" Belt Sander
___5" - 8" Drill Press
___8" Table Saw
___8" - 10" Bandsaw
___Disc/Belt Sander
___Mini Jointer
___6" - 8" Grinder
___Mini Lathe
___10" - 12" Thickness Planer
___Scroll Saw
___Spindle/Belt Sander

___Other_____

11. How many of the machines checked above are Grizzly? _____

12. Which portable/hand held power tools do you own? Check all that apply.

___Belt Sander
___Biscuit Joiner
___Circular Saw
___Detail Sander
___Drill/Driver
___Miter Saw
___Orbital Sander
___Palm Sander
___Portable Planer
___Saber Saw
___Reciprocating Saw
___Router

___Other_____

13. What machines/supplies would you like Grizzly Industrial to carry?

_____

_____

_____

14. What new accessories would you like Grizzly Industrial to carry?

_____

_____

_____

15. What other companies do you purchase your tools and supplies from?

_____

_____

16. Do you think your purchase represents good value?

___Yes ___No

17. Would you recommend Grizzly Imports to a friend?

___Yes ___No

18. Would you allow us to use your name as a reference for Grizzly customers in your area? **Note: We never use names more than three times.**

___Yes ___No

19. Comments:_____

_____

_____

_____

_____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

Place
Stamp
Here

GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069

FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE